

CORROSION OF VANADIUM BY MOLTEN BISMUTH

Kurt D. Richards

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CORROSION OF VANADIUM BY MOLTEN BISMUTH

By

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Submitted in Partial Fulfillment of the Requirements

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CORROSION OF VANADIUM BY MOLTEN BISMUTH

by

Eurt D. Richards, Lt., USN

Submitted to the Department of Chemical Engineering on July 20, 1955, in partial fulfillment of the requirements for the degree of Master of Science.

ABSTRACT

In this study vanadium was evaluated as a container material for molten bismuth in a liquid-metal-cooled system. A rough appraisal of vanadium as a container material for sodium was also included.

The investigation took two forms. The first series of tests utilized crucibles of vanadium containing bismuth. Results were determined in terms of three independent variables, viz: temperature, time, and degree of agitation. Dependent variables were (1) solubility of vanadium in bismuth and (2), depth and type of corrosive penetration.

The second series of tests utilized tubes of vanadium containing a small amount of bismuth. The tubes were tilted at five minute intervals while the ends of the tubes were maintained at constant but widely separated temperatures. Deposits in low low temperature end furnished physical evidence of thermal gradient mass transport.

Results demonstrated that vanadium

1. was susceptible to mechanical (corrosion-erosion) attack by bismuth between

- temperatures of 550°C and 700°C ,
2. had high solubility in bismuth,
 3. suffered severe intergranular corrosive attack at temperatures above 900°C
 4. demonstrated a strong propensity for thermal gradient mass transport,
 5. was attacked, during the mass transfer experiments, at a particularly rapid rate in the high temperature region because of the cyclic removal of dissolved vanadium in the low temperature region.

In the included experiments with molten sodium, the vanadium showed little resistance to attack.

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TABLE OF CONTENTS

<u>Subject</u>	<u>Page</u>
Title Page	i
Abstract	ii
List of Illustrations	vi
List of Tables	viii
Acknowledgment	ix
I. SUMMARY	1.
II. INTRODUCTION	3.
III. PROCEDURE	7.
A. Corrosion	7.
1. Apparatus	7.
2. Specimens	7.
3. Testing procedures	9.
4. Analysis	9.
B. Mass transfer tests	16.
1. Apparatus	16.
2. Specimens	17.
3. Analysis	17.
IV. RESULTS	12.
A. Corrosion test - Vanadium by bismuth	19.
1. Chemical analysis	19.
2. Metallographic analysis	19.
3. Crucible failure	19.
4. Wetting of surfaces	22.
B. Corrosion tests - Croloy 5 Si by bismuth	23.
C. Corrosion tests - vanadium by sodium	23.
1. Physical evidence	23.

TABLE OF CONTENTS

Page	Subject
1	Introduction
2	1. General
3	2. Specific
4	3. Detailed
5	4. Summary
6	5. Conclusion
7	6. Appendix
8	7. Bibliography
9	8. Index
10	9. Glossary
11	10. List of Figures
12	11. List of Tables
13	12. List of Abbreviations
14	13. List of Symbols
15	14. List of Equations
16	15. List of References
17	16. List of Figures
18	17. List of Tables
19	18. List of Abbreviations
20	19. List of Symbols
21	20. List of Equations
22	21. List of References
23	22. List of Figures
24	23. List of Tables
25	24. List of Abbreviations
26	25. List of Symbols
27	26. List of Equations
28	27. List of References
29	28. List of Figures
30	29. List of Tables
31	30. List of Abbreviations
32	31. List of Symbols
33	32. List of Equations
34	33. List of References
35	34. List of Figures
36	35. List of Tables
37	36. List of Abbreviations
38	37. List of Symbols
39	38. List of Equations
40	39. List of References
41	40. List of Figures
42	41. List of Tables
43	42. List of Abbreviations
44	43. List of Symbols
45	44. List of Equations
46	45. List of References
47	46. List of Figures
48	47. List of Tables
49	48. List of Abbreviations
50	49. List of Symbols
51	50. List of Equations
52	51. List of References
53	52. List of Figures
54	53. List of Tables
55	54. List of Abbreviations
56	55. List of Symbols
57	56. List of Equations
58	57. List of References
59	58. List of Figures
60	59. List of Tables
61	60. List of Abbreviations
62	61. List of Symbols
63	62. List of Equations
64	63. List of References
65	64. List of Figures
66	65. List of Tables
67	66. List of Abbreviations
68	67. List of Symbols
69	68. List of Equations
70	69. List of References
71	70. List of Figures
72	71. List of Tables
73	72. List of Abbreviations
74	73. List of Symbols
75	74. List of Equations
76	75. List of References
77	76. List of Figures
78	77. List of Tables
79	78. List of Abbreviations
80	79. List of Symbols
81	80. List of Equations
82	81. List of References
83	82. List of Figures
84	83. List of Tables
85	84. List of Abbreviations
86	85. List of Symbols
87	86. List of Equations
88	87. List of References
89	88. List of Figures
90	89. List of Tables
91	90. List of Abbreviations
92	91. List of Symbols
93	92. List of Equations
94	93. List of References
95	94. List of Figures
96	95. List of Tables
97	96. List of Abbreviations
98	97. List of Symbols
99	98. List of Equations
100	99. List of References

<u>Subject</u>	<u>Page</u>
2. Chemical analysis	24.
3. Metallographic examination	24.
4. X-ray spectrographic analysis	24.
V. DISCUSSION OF RESULTS	43.
A. Corrosion tests	43.
1. Solubility tests	43.
2. Corrosion and corrosion-erosion	43.
B. Corrosion-erosion of vanadium by sodium	44.
C. Thermal gradient mass transport tests	45.
VI. CONCLUSIONS	46.
VII. RECOMMENDATIONS	47.
VIII. APPENDIX	
Appendix A	46.
Appendix B	53.
Appendix C	57.
1. Determination of vanadium in bismuth	57.
a. Preparation for chemical analysis	57.
b. Chemical procedure	57.
2. Determination of Vanadium sodium	58.
3. Determination of Iron in bismuth	60.
Appendix D	62.
Appendix E	64.
IX. BIBLIOGRAPHY	66.

1	General description of the work	1
2	1. General description of the work	2
3	2. General description of the work	3
4	3. General description of the work	4
5	4. General description of the work	5
6	5. General description of the work	6
7	6. General description of the work	7
8	7. General description of the work	8
9	8. General description of the work	9
10	9. General description of the work	10
11	10. General description of the work	11
12	11. General description of the work	12
13	12. General description of the work	13
14	13. General description of the work	14
15	14. General description of the work	15
16	15. General description of the work	16
17	16. General description of the work	17
18	17. General description of the work	18
19	18. General description of the work	19
20	19. General description of the work	20
21	20. General description of the work	21
22	21. General description of the work	22
23	22. General description of the work	23
24	23. General description of the work	24
25	24. General description of the work	25
26	25. General description of the work	26
27	26. General description of the work	27
28	27. General description of the work	28
29	28. General description of the work	29
30	29. General description of the work	30
31	30. General description of the work	31
32	31. General description of the work	32
33	32. General description of the work	33
34	33. General description of the work	34
35	34. General description of the work	35
36	35. General description of the work	36
37	36. General description of the work	37
38	37. General description of the work	38
39	38. General description of the work	39
40	39. General description of the work	40
41	40. General description of the work	41
42	41. General description of the work	42
43	42. General description of the work	43
44	43. General description of the work	44
45	44. General description of the work	45
46	45. General description of the work	46
47	46. General description of the work	47
48	47. General description of the work	48
49	48. General description of the work	49
50	49. General description of the work	50
51	50. General description of the work	51
52	51. General description of the work	52
53	52. General description of the work	53
54	53. General description of the work	54
55	54. General description of the work	55
56	55. General description of the work	56
57	56. General description of the work	57
58	57. General description of the work	58
59	58. General description of the work	59
60	59. General description of the work	60
61	60. General description of the work	61
62	61. General description of the work	62
63	62. General description of the work	63
64	63. General description of the work	64
65	64. General description of the work	65
66	65. General description of the work	66
67	66. General description of the work	67
68	67. General description of the work	68
69	68. General description of the work	69
70	69. General description of the work	70
71	70. General description of the work	71
72	71. General description of the work	72
73	72. General description of the work	73
74	73. General description of the work	74
75	74. General description of the work	75
76	75. General description of the work	76
77	76. General description of the work	77
78	77. General description of the work	78
79	78. General description of the work	79
80	79. General description of the work	80
81	80. General description of the work	81
82	81. General description of the work	82
83	82. General description of the work	83
84	83. General description of the work	84
85	84. General description of the work	85
86	85. General description of the work	86
87	86. General description of the work	87
88	87. General description of the work	88
89	88. General description of the work	89
90	89. General description of the work	90
91	90. General description of the work	91
92	91. General description of the work	92
93	92. General description of the work	93
94	93. General description of the work	94
95	94. General description of the work	95
96	95. General description of the work	96
97	96. General description of the work	97
98	97. General description of the work	98
99	98. General description of the work	99
100	99. General description of the work	100

LIST OF ILLUSTRATIONS

		<u>Page</u>
FIGURE	1. Furnace Apparatus	6
FIGURE	2. Corrosion Test Specimens	10
FIGURE	3. Mass Transfer Test Specimens	11
FIGURE	4. Solubility of Crucible Material in Bismuth	21
FIGURE	5. Crucible surface, 550°C, 24 hours	27
FIGURE	6. Crucible surface, 550°C, 360 hours	28
FIGURE	7. Crucible surface, 630°C, 96 hours	29
FIGURE	8. Crucible surface, 720°C, 96 hours	30
FIGURE	9. Crucible surface, 800°C, 24 hours	31
FIGURE	10. Crucible surface, 800°C, 336 hours	32
FIGURE	11. Crucible surface, 900°C, 96 hours	33
FIGURE	12. Crucible surface, 1000°C, 24 hours	34
FIGURE	13. Crucible surface, 1000°C, 72 hours	35
FIGURE	14. Surfaces of steel crucibles containing bismuth	36
FIGURE	15. Surfaces of vanadium crucibles containing sodium	37
FIGURE	16. Macrograph of cross sections of low temperature ends of mass transfer tilt tubes	38
FIGURE	17. Macrophotographs of high temperature ends of tilt tubes	39
FIGURE	18. Photomicrograph of high temperature ends of mass transfer tilt tubes	40
FIGURE	19. Photomicrograph of deposit in low temperature end of tilt tube.	41
FIGURE	20. Photomicrograph of deposit in low temperature end of tilt tube	42

Page	Description	Amount
1	Balance forward	100.00
2	Received from John Doe	50.00
3	Received from Jane Smith	25.00
4	Received from Mr. Brown	75.00
5	Received from Mrs. Green	30.00
6	Received from Mr. White	40.00
7	Received from Mr. Black	60.00
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	<u>Page</u>
FIGURE 21. Wiring and Control Circuit for Five-Region	52
FIGURE 22. Arc furnace used for welding	56
FIGURE 23. Electronic Interval Timer Circuit	65

LIST OF TABLESPage

TABLE I (a):	Schedule of Test periods for vanadium crucibles containing bismuth	12
TABLE I (b):	Schedule of test periods for steel crucibles containing bismuth	13
TABLE I (c):	Schedule of test periods for vanadium crucibles containing sodium	14
TABLE II :	Corrosion test data sheet	20
TABLE III :	Data on Mass Transfer Test	25

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CONFIDENTIAL

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I SUMMARY

The purpose of this study was to evaluate vanadium as a container material for molten bismuth in a liquid-metal-cooled system. A rough appraisal of vanadium as a container material for sodium was also included.

The investigation took two form. The first series of tests utilized crucibles of vanadium containing bismuth. Results were determined in terms of three independent variables, viz.: temperature, time, and degree of agitation. Dependent variables were (1) solubility of vanadium in bismuth, determined by chemical analysis, and (2), depth and type of corrosive penetration, determined by metallographic inspection.

The second series of tests utilized tubes of vanadium containing a small amount of bismuth. The tubes were tilted at five minute intervals while the ends of the tubes were maintained at constant but widely separated temperatures. Deposits in the low temperature end furnished physical evidence of thermal gradient mass transport. Cold-end deposits were analyzed chemically. Identification of deposits were checked by X-ray spectrographic analysis. Identification of the form taken by the deposit was made by metallographic inspection. Corrosive attack of

the high temperature end of the tube was also studied metallographically.

Results were unfavorable. The vanadium:

1. was susceptible to mechanical (corrosion-erosion) attack by bismuth between temperatures of 550°C and 700°C ,
2. had high solubility in bismuth, solubility varying almost linearly with temperature,
3. suffered severe intergranular corrosive attack at temperatures of 900°C and above,
4. demonstrated a strong propensity for thermal gradient mass transport,
5. was attacked, during the mass transfer experiments, at a particularly rapid rate in the high temperature region because of the cyclic removal of dissolved vanadium in the low temperature region.

In the included experiments with molten sodium, the vanadium showed little resistance to attack.

The first experiment was to see how the subjects
performed on the task.

Subjects were instructed to perform the task as quickly and accurately as possible. The results of the first experiment are shown in Table 1. The subjects performed the task with a mean accuracy of 85% and a mean response time of 1.2 seconds.

The second experiment was to see how the subjects performed on the task when the task was made more difficult. The results of the second experiment are shown in Table 2. The subjects performed the task with a mean accuracy of 75% and a mean response time of 1.5 seconds.

The third experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the third experiment are shown in Table 3. The subjects performed the task with a mean accuracy of 65% and a mean response time of 1.8 seconds.

The fourth experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the fourth experiment are shown in Table 4. The subjects performed the task with a mean accuracy of 55% and a mean response time of 2.1 seconds.

The fifth experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the fifth experiment are shown in Table 5. The subjects performed the task with a mean accuracy of 45% and a mean response time of 2.4 seconds.

The sixth experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the sixth experiment are shown in Table 6. The subjects performed the task with a mean accuracy of 35% and a mean response time of 2.7 seconds.

The seventh experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the seventh experiment are shown in Table 7. The subjects performed the task with a mean accuracy of 25% and a mean response time of 3.0 seconds.

The eighth experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the eighth experiment are shown in Table 8. The subjects performed the task with a mean accuracy of 15% and a mean response time of 3.3 seconds.

The ninth experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the ninth experiment are shown in Table 9. The subjects performed the task with a mean accuracy of 5% and a mean response time of 3.6 seconds.

The tenth experiment was to see how the subjects performed on the task when the task was made even more difficult. The results of the tenth experiment are shown in Table 10. The subjects performed the task with a mean accuracy of 0% and a mean response time of 3.9 seconds.

The results of the ten experiments show that the subjects performed the task with a mean accuracy of 55% and a mean response time of 1.5 seconds.

II INTRODUCTION

A. Background

Molten bismuth has many properties which make it a highly desirable coolant in nuclear reactors. It has low neutron absorption cross-section, a high transport cross-section, and excellent alloying characteristics with uranium. It has a relatively low melting point (268°C) combined with a high boiling point (1460°C). Although its specific heat is quite low, its high density gives it good heat transfer characteristics on a volumetric basis. Efforts to utilize its advantages in a liquid-metal-cooled or a liquid-metal-fueled reactor have launched a search for a good container material for molten bismuth. Such a material must, among other things:

- (1) not be corroded by the molten bismuth,
- (2) have favorable microscopic nuclear characteristics
- (3) resist mass transport in circulation loops involving temperature cycling.
- (4) have suitable high-temperature strength and creep resistance,
- (5) be reasonably easy to fabricate,

1. Introduction

1.1. Background

Before discussing the many properties which make it a highly desirable material in certain respects, it has few negative attributes (such as weight, a high modulus of elasticity, and excellent electrical conductivity) to be mentioned. It has a relatively low melting point (1200°C) compared with a high boiling point (2500°C), although its specific heat is quite low, and this quality gives it good heat transfer characteristics in a relatively small volume. It is also the only material in which the liquid phase is a liquid-crystalline phase. It is a liquid-crystalline material and has a high melting point and a high boiling point. It is a liquid-crystalline material and has a high melting point and a high boiling point. It is a liquid-crystalline material and has a high melting point and a high boiling point.

- (1) It is not so common as the other materials.
- (2) It has a relatively high melting point.
- (3) It is a liquid-crystalline material.
- (4) It has a high melting point and a high boiling point.
- (5) It is a liquid-crystalline material.
- (6) It has a high melting point and a high boiling point.
- (7) It is a liquid-crystalline material.
- (8) It has a high melting point and a high boiling point.
- (9) It is a liquid-crystalline material.
- (10) It has a high melting point and a high boiling point.

Vanadium, when considered as a possible container material for molten bismuth, has received rather cursory but generally favorable mention (1). Preliminary static tests used to screen out obviously unsuitable materials indicate that vanadium resists corrosion by molten bismuth. More exhaustive tests on these materials showing promise have naturally been focused first upon the ones which were most attractive from the stand-points of economy and ease of fabrication.

B. Scope

Investigations of the corrosion of vanadium by bismuth, and thermal gradient mass transport in a vanadium system involving thermal cycling of molten bismuth, were established as the primary aims of this study.

1. Corrosion studies

Corrosion of a solid metal by a molten metal is minimal when either the free energy of the reaction is positive, or when an intermetallic film or protective layer is formed through which the diffusion rates are small (3). It was assumed, as a working hypothesis, that some kind of intermetallic film would be formed in a vanadium-bismuth system, and the apparatus was designed in such a way as to subject this (assumed) film to varying degrees of agitation. Erosion of the film and of the inner surfaces of the container were expected to vary the results of the

Verfahren: Zwei unabhängige Stichproben

which were used extensively from the year 1900 to 1910.

William H. McWhorter and Robert McWhorter, Jr., are
the authors of the book "The American Revolution and the
American Mind" published by the University of Chicago Press.
The book is a study of the American Revolution and the
American mind.

minimal when it comes to the study of the function of the
positive, or when it is necessary to find out how the
it is found through the study of the function of the
it is found, or a variety of other, that some kind of
however, the study of the function of the
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corrosion tests. For purposes of comparison, containers of a 5% chromium - 1½% silicon steel were included in the runs. This steel, known as Croloy 5 Si, has been the subject of extensive tests at Brookhaven National Laboratory (2). In addition, at test temperatures below the boiling point of sodium, vanadium crucibles containing sodium were included for rough qualitative test of resistance of vanadium to attack by molten sodium.

Test and analysis procedures for this series of tests were designed to develop a broad range of information in a relatively short time rather than to achieve pin-point accuracy. They were principally intended to indicate the direction of any further investigation.

2. Thermal gradient mass transport studies

When solubility of the solid, or container, metal varies widely with changes of temperature, there is a probability that mass transfer will occur in a closed loop system involving physical circulation and simultaneous thermal cycling. Container metal, going into solution at the high temperature, precipitates out and forms a metallic growth or mass in the lower temperature region. Concomitantly, the removal of the dissolved component from the circulating material accelerates corrosion attack in the high temperature region (3). The tilt-tube process used in this investigation offers a simple and rapid test for mass

[illegible]

transfer. The ends of a long tube of the container material are maintained at constant temperatures, one high, the other low, and the tube is tilted back and forth so that the contained molten metal is subjected to sudden and severe thermal cycling. Under these conditions, mass transport, when it occurs, may be expected to be severe and unmistakable.

C. Classification

For simplicity of handling and dissemination it was decided, upon advice of the thesis supervisor, to keep this report unclassified. Because of its narrow scope and in the light of similar reports in the literature, this study is clearly of an unclassified nature; however, information pertinent to the testing procedures and previous work done on allied subjects is often contained in compilations or in combination with classified material. Quotations from classified literature, either directly or indirectly, is therefore impossible and has been rigorously avoided. A list of classified literature containing pertinent material is included in the bibliography but not referred to in the text.

[illegible]

III PROCEDURE

A. Corrosion Tests

1. Apparatus

An electric furnace, eighteen inches in overall length, was wound and energized in such a way that isothermal conditions could be maintained over a fourteen inch length of its interior. Details of furnace construction are contained in Appendix A. The furnace was mounted on a teeter-board tilting 20° from the horizontal in each direction on bearings located in line with the center of the furnace. A motor-driven crank arm lifted the weighted teeter-board through the horizontal (the point of unstable equilibrium) from where it dropped freely the remaining 20° onto a spring which bounced it several times. This action was repeated twelve times per minute. The purpose was to subject specimens placed in the center of the furnace to a mild form of agitation, little more than a tilting action, whereas specimens located away from the center received repeated jolting, progressively increasing in violence as the ends of the furnace are approached. Figure 1 is a diagram of the furnace mechanism.

2. Specimens

Specimens were small cylindrical crucibles of vanadium and of Croly 5 Si type steel. Interior dimensions were 0.25 inches in diameter by 1.00 inch in length.

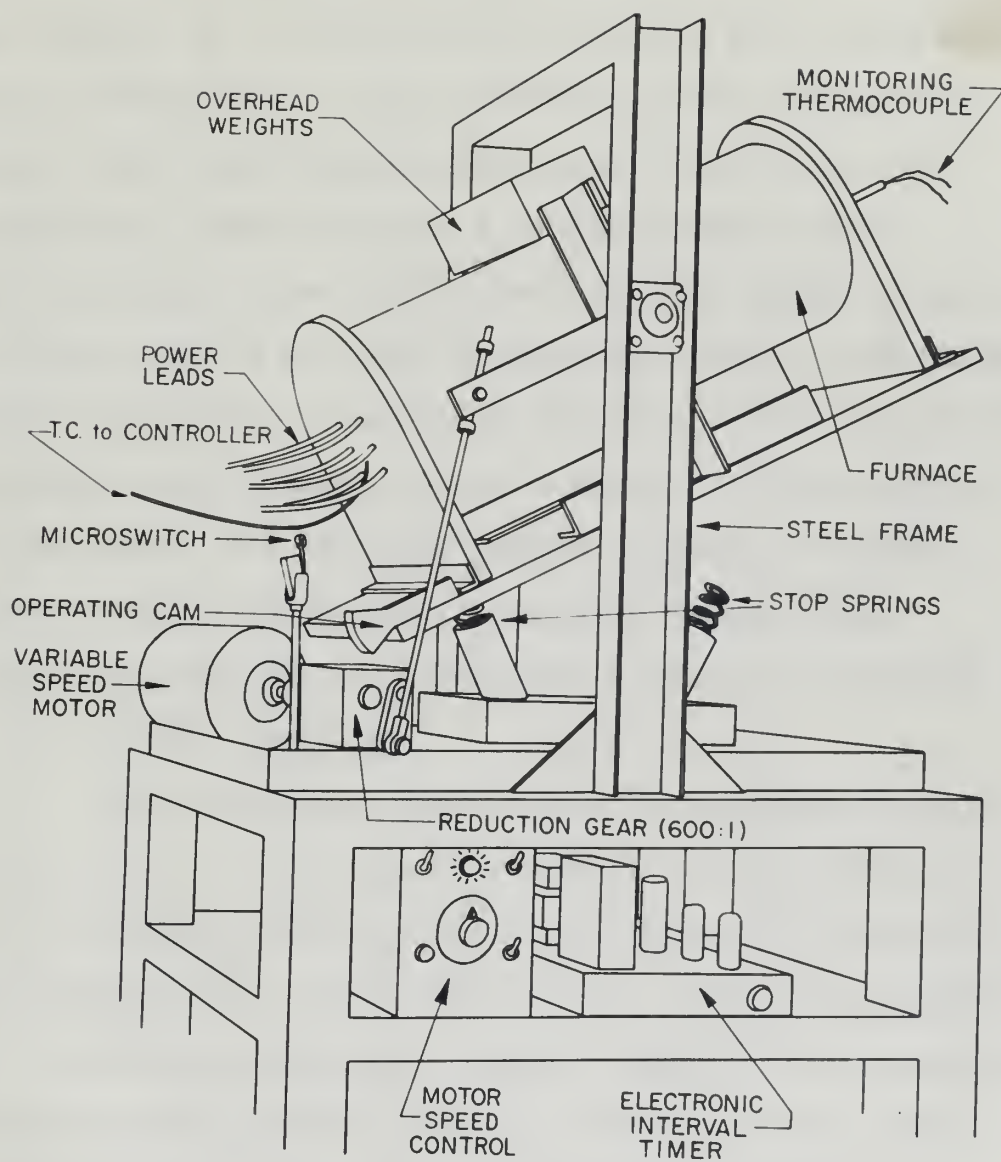


FIGURE 1 FURNACE APPARATUS

Crucible construction and dimension are shown in Figure 2. A few of the crucibles were filled about one half full (approximately 4.5 gram) with purified bismuth. The inner surface of the cap was polished for later metallographic examination. Inner surfaces of the rest of the crucible were reamed smooth and pickled in nitric acid. The crucibles were placed in a tight-fitting copper jacket which was water cooled and the caps welded on with an electric arc in an argon atmosphere using a water-cooled tungsten electrode. Cooling of the body of the crucible during welding was dictated by the necessity of completing the weld before the contained metal (sodium or bismuth) reached boiling temperature. Crucible fabrication, loading, and welding are discussed in detail in Appendix B.

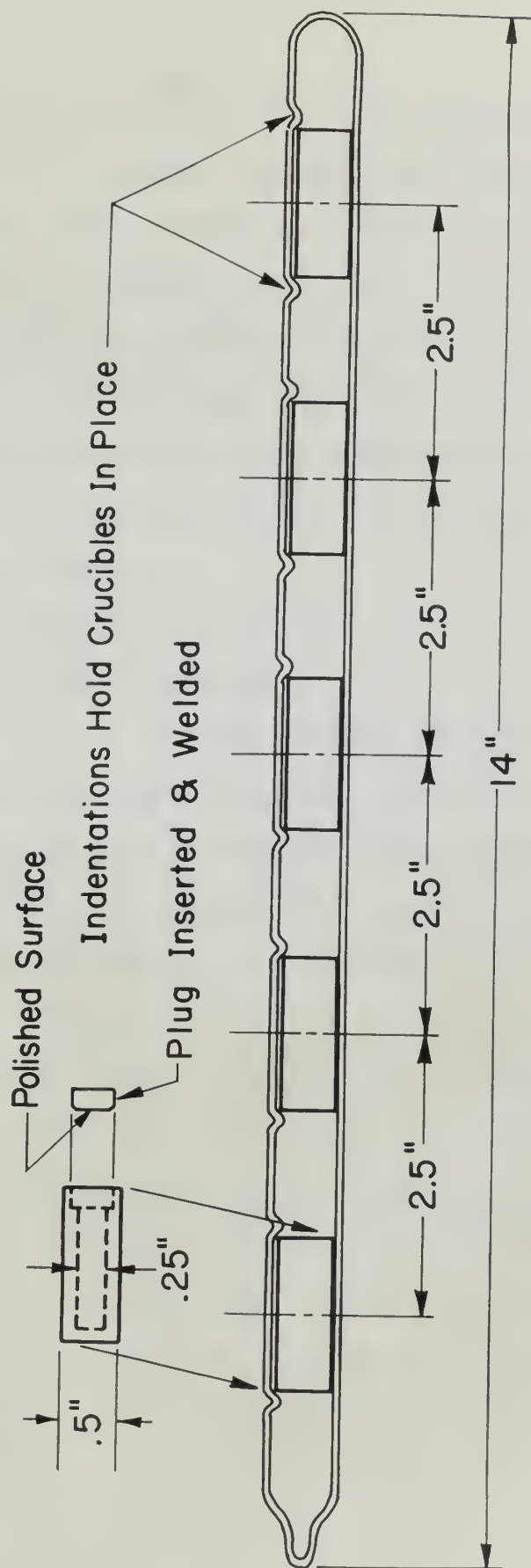
3. Testing procedures

The crucibles were wrapped in tantalum foil and placed, five to a tube, in Vycor glass tubing, fourteen inches in length overall, which was subsequently evacuated and sealed off. Depressions in the glass tube maintained the crucibles rigidly in place. Crucibles were mounted $2\frac{1}{4}$ inches apart at their centers, overall crucible displacement being 12 inches, end to end. Mounting of crucibles is shown in Figure 2. The center position in each tube was occupied by a vanadium crucible containing bismuth which received mild agitation. The two end

Cylindrical construction and dimensions are shown in Figure 2. A lot of the crystals were filled about one half full (approximately 1.5 liter) with distilled water. The front surface of the can was polished the same material previously mentioned. The front surface of the rest of the crystals were ground smooth and polished in alkali bath. The crystals were placed in a light-tight bag. The front surface was water cooled and the back welded in with an electrode and in an argon atmosphere using a water-cooled tungsten electrode. Cooling of the body of the crystals and the welding was directed by the necessity of maintaining the wall between the front and back (bottom or top) of the crystal being investigated. The front surface was polished and welded and the back was polished in alkali bath. 2. Cooling equipment.

The crystals were cooled in ammonia gas and placed in a glass or steel in front glass vessel, front surface in front vessel, back was successively covered of the vessel only. The crystals in the glass tube maintain at the crystalline slightly in glass. Crystals were cooled 2 1/2 inches apart at their centers, several crystals at a distance being in inches, and in 100, 1000 of crystals is shown in Figure 3. The center position in each tube was controlled by a sensitive crystal containing elements which reacted with nitrogen. The two end

Figure 2 Corrosion Test Specimens



V-Crucibles, Each Containing 4 Grams of Bi

positions, subjected to the most severe agitation were occupied by a vanadium crucible and steel crucible, respectively, both containing bismuth. Intermediate positions were not filled in all runs. When filled, they were occupied by vanadium crucibles, one containing bismuth the other containing sodium. In terms of the three independent variables introduced in these tests, crucibles were placed in the furnace according to the schedule of Table 1.

4. Analysis procedures

(a) Chemical

Upon removal from the furnace, crucibles were set vertically, without cooling, for a short time so that particles eroded from the inside of the crucibles had opportunity to settle at the end, then quenched rapidly in cold water. It was expected that the crucible metal taken into solution by the bismuth might precipitate out upon quenching but that freezing would occur so rapidly that this precipitate would remain in suspension. The cap, bearing the prepared surface, was then cut off and prepared for metallographic inspection. Those crucibles containing bismuth were chucked in a lathe and the crucible and outer surface of the bismuth turned off. The remaining bismuth was cleaned by dissolving to about 2/3 of

positions, situated so that they receive radiation from
 directly by a vertical window and solar radiation, the
 windows, with constant diameter, 100 mm. The
 area was not filled in all cases, some times, and
 was covered by various materials, and sometimes
 during the other constant radiation. In some of the
 very important experiments, however, in some cases,
 specimens were placed in the vacuum chamber to the

results of Table 1.

4. Analysis procedures

(a) Chemical

The chemical analysis was carried out as follows:

specimens were not analyzed, because of the
 about time as that required for the analysis of
 the specimens and approximately the same at the end,
 then removed rapidly to cold water. It was expected
 that the available metal would be in solution by the
 chemical analysis, but upon examination it was
 found that some of the specimens were not completely
 dissolved in water. The day, during the two-
 week period, was then not all and removed for
 analysis. The specimens were then removed for
 analysis and placed in a bath of the solution and
 under surface of the liquid glass oil. The results
 for chemical analysis were then as follows:

Temperature (degrees C)	Mild Agitation	Intermediate Agitation	Severe Agitation
550	24 hours	24 hours	24 hours
550	96 "	96 "	96 "
550	218 "	218 "	218 "
550	360 "	360 "	360 "
670	96 hours		96 hours
720	96 hours		96 hours
800	24 hours	24 hours	24 hours
800	48 "	48 "	48 "
800	96 "	96 "	96 "
800	192 "	192 "	192 "
800	338 "	338 "	338 "
900	96 hours		96 hours
1000	24 hours		24 hours
1000	72 "		72 "
1000	144 "		144 "

TABLE X (a) Schedule of test periods for vanadium crucibles
containing bismuth

Subject	Grade	Score	Comments
Mathematics	100	100	Excellent
Science	95	95	Very Good
History	90	90	Good
Language Arts	85	85	Good
Physical Education	80	80	Good
Art	75	75	Good
Music	70	70	Good
Health	65	65	Good
Foreign Languages	60	60	Good
Electives	55	55	Good
Practical Training	50	50	Good
Physical Education	45	45	Good
Art	40	40	Good
Music	35	35	Good
Health	30	30	Good
Foreign Languages	25	25	Good
Electives	20	20	Good
Practical Training	15	15	Good
Physical Education	10	10	Good
Art	5	5	Good
Music	0	0	Good

Temperature (degrees C)	Mild Agitation	Intermediate Agitation	Severe Agitation
550			24 hours
550			96 "
550			216 "
550			360 "
650			96 hours
720			96 hours
800			24 hours
800			48 hours
800			96 hours
800			192 hours
800			336 hours
900			96 hours
1000			24 hours
1000			72 "
1000			144 "

TABLE I (b) Schedule of test periods for steel crucibles
containing blisath

Software Tools for Modeling and Simulation 177 © 2007

Project Name	Project Number	Project Description	Project Status
Project A	101	Project A Description	Completed
Project B	102	Project B Description	In Progress
Project C	103	Project C Description	On Hold
Project D	104	Project D Description	Not Started
Project E	105	Project E Description	Completed
Project F	106	Project F Description	In Progress
Project G	107	Project G Description	On Hold
Project H	108	Project H Description	Not Started
Project I	109	Project I Description	Completed
Project J	110	Project J Description	In Progress

Temperature (degrees C)	Mild Agitation	Intermediate Agitation	Severe Agitation
550		24 hours	
550		96 "	
550		218 "	
550		360 "	
600		24 hours	
650		48 "	
700		96 "	
800		192 "	
800		338 "	

TABLE I (c) Schedule of test periods for vanadium crucibles
containing sodium

TABLE I
 Relative retention times of various compounds in the gas chromatogram (a) and in the mass spectrum (b)

Compound	Retention time (min)	Mass spectrum (m/z)
1	10.5	43
2	11.2	43
3	12.8	43
4	13.5	43
5	14.2	43
6	15.8	43
7	16.5	43
8	17.2	43
9	18.8	43
10	19.5	43
11	20.2	43
12	21.8	43
13	22.5	43
14	23.2	43
15	24.8	43
16	25.5	43
17	26.2	43
18	27.8	43
19	28.5	43
20	29.2	43
21	30.8	43
22	31.5	43
23	32.2	43
24	33.8	43
25	34.5	43
26	35.2	43
27	36.8	43
28	37.5	43
29	38.2	43
30	39.8	43
31	40.5	43
32	41.2	43
33	42.8	43
34	43.5	43
35	44.2	43
36	45.8	43
37	46.5	43
38	47.2	43
39	48.8	43
40	49.5	43
41	50.2	43
42	51.8	43
43	52.5	43
44	53.2	43
45	54.8	43
46	55.5	43
47	56.2	43
48	57.8	43
49	58.5	43
50	59.2	43
51	60.8	43
52	61.5	43
53	62.2	43
54	63.8	43
55	64.5	43
56	65.2	43
57	66.8	43
58	67.5	43
59	68.2	43
60	69.8	43
61	70.5	43
62	71.2	43
63	72.8	43
64	73.5	43
65	74.2	43
66	75.8	43
67	76.5	43
68	77.2	43
69	78.8	43
70	79.5	43
71	80.2	43
72	81.8	43
73	82.5	43
74	83.2	43
75	84.8	43
76	85.5	43
77	86.2	43
78	87.8	43
79	88.5	43
80	89.2	43
81	90.8	43
82	91.5	43
83	92.2	43
84	93.8	43
85	94.5	43
86	95.2	43
87	96.8	43
88	97.5	43
89	98.2	43
90	99.8	43
91	100.5	43
92	101.2	43
93	102.8	43
94	103.5	43
95	104.2	43
96	105.8	43
97	106.5	43
98	107.2	43
99	108.8	43
100	109.5	43

former size in nitric acid. This was then divided into two two parts and the parts individually analyzed chemically as a check for homogeneity. Analyses of the two parts are listed separately in Table II. The standard determination for vanadium (potassium perchlorate-sulfuric acid) could not be utilized because of interference with the test by the bismuth, and use of a considerably less accurate colorimetric test for vanadium was enforced. Appendix C details chemical analysis procedures utilized.

Crucibles containing sodium were cut open and immersed in distilled water. After the reaction had subsided, the crucible was removed and its interior was flushed with distilled water, the washings being added to the solution. The sodium content was determined from analysis of the sodium hydroxide formed. All solid particles remaining were taken into solution with acid and the resulting solution tested for amount of vanadium present.

(b) Metallographic

The caps were sectioned perpendicularly to the prepared surface, mounted in plastic and polished. Without etching, the surfaces were examined by means of a metallograph. To prevent personal bias or predilection, an independent observer, not appraised of the specimen test conditions, examined the entire cross section of the surface exposed to corrosive action.

The observer then selected a representative section typifying the conditions of the surface, and this section was photographed.

B. Mass transfer tests

1. Apparatus

For this set of tests the previously described furnace was energized in such a way as to provide a localized point of high temperature near its center. An electronic interval timer was used to interrupt motor action so that the furnace was tilted down on the alternate end every five minutes. The bouncing action described in previous section was damped out. Appendix E discusses the switch and timer action for cycle control in the tilt-tube mass transfer tests.

Two large cylindrical blocks of stainless steel were fabricated to fit over $1\frac{1}{2}$ inches of each end of the tilt-tube specimens. These blocks acted as heat reservoirs and were used to stabilize the temperatures of the ends of the tilt-tubes. Thermocouples inserted in the blocks were used to monitor tilt-tube end temperatures. The tilt-tube heat-reservoir-blocks assembly is shown in Figure 3.

One block was maintained at 900°C . The other block stabilized at 390°C when three tilt-tubes were in operation simultaneously, at 320°C when two tubes were in operation,

The chamber was filled with a dry atmosphere and the
pressure was maintained at 100 mm. Hg. The reaction
was followed.

It was found that

1. The reaction

At this rate of reaction the reaction was
followed by measuring the amount of gas evolved
at regular intervals of time. The reaction was
found to be first order with respect to the
concentration of the reactant. The rate of
reaction was found to be independent of the
concentration of the other reactant. The
activation energy was found to be 15,000 cal./mole.
The reaction was found to be reversible.

The reaction was found to be reversible. The
equilibrium constant was found to be 1.5 at 25°C.
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equilibrium constant was found to be 1.5 at 25°C.
The reaction was found to be reversible. The
equilibrium constant was found to be 1.5 at 25°C.
The reaction was found to be reversible. The
equilibrium constant was found to be 1.5 at 25°C.

Figure 1. The reaction was found to be reversible.
The equilibrium constant was found to be 1.5 at 25°C.
The reaction was found to be reversible. The
equilibrium constant was found to be 1.5 at 25°C.

and was held at 300°C (by addition of external heat) when only one tube was left.

2. Specimens

Specimens were eight inch long tubes of vanadium drilled from extruded rod as discussed in Appendix D. A tilt-tube for the mass transfer test is depicted in Figure 3. Caps with polished inner surfaces, were welded over the ends. Contents were ten grams of bismuth. The vanadium tubes were wrapped with tantalum foil and placed in Vycor glass tubes, evacuated, and sealed. The wrapped vanadium specimens were made to fit tightly in the glass tubes in order to attain good heat transfer.

3. Analysis

At selected time intervals the tilt-tube assembly was opened and a tube removed. The tube was quenched vertically with the high temperature end down. Ends of the tube were cut off and sectioned. One half of the low temperature end was polished for X-ray spectographic analysis and for retention as physical evidence of mass transfer. The deposit in the other half was carefully chipped out and used for chemical analysis. The high-temperature end was sectioned and polished for metallographic examination.

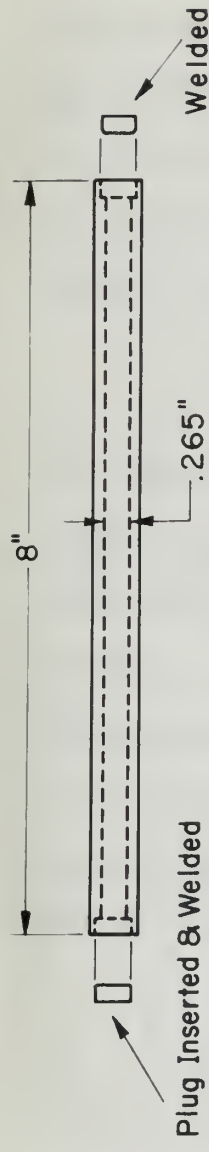
and was built in 1907 (by addition of several feet) from
only one half ton of iron.

2. Foundation

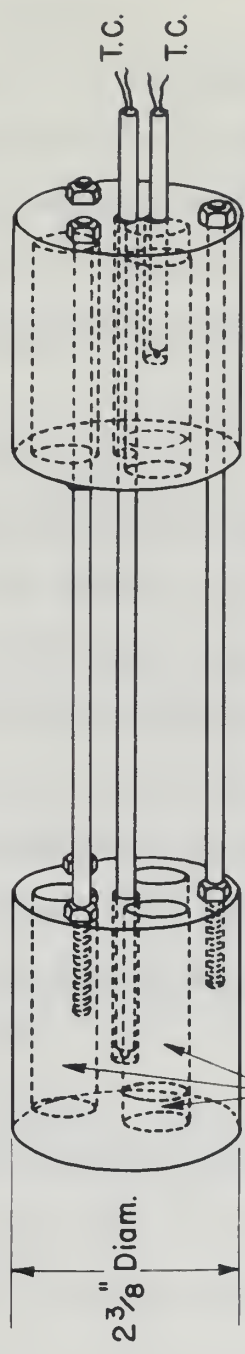
Foundation was built from long pieces of
weathered granite from the mountain and is situated in some-
what of a dip-slope for the most part. It is situated
in front of the house with a slight dip towards the house.
The foundation was built with concrete and is
about 10 feet high, 10 feet wide, and 10 feet deep. The
foundation was built with concrete and is about 10 feet
high, 10 feet wide, and 10 feet deep. The foundation was
built with concrete and is about 10 feet high, 10 feet
wide, and 10 feet deep. The foundation was built with
concrete and is about 10 feet high, 10 feet wide, and
10 feet deep. The foundation was built with concrete and
is about 10 feet high, 10 feet wide, and 10 feet deep.

3. Structure

The structure is built with concrete and is about 10 feet
high, 10 feet wide, and 10 feet deep. The structure is
built with concrete and is about 10 feet high, 10 feet
wide, and 10 feet deep. The structure is built with
concrete and is about 10 feet high, 10 feet wide, and
10 feet deep. The structure is built with concrete and
is about 10 feet high, 10 feet wide, and 10 feet deep.
The structure is built with concrete and is about 10 feet
high, 10 feet wide, and 10 feet deep. The structure is
built with concrete and is about 10 feet high, 10 feet
wide, and 10 feet deep. The structure is built with
concrete and is about 10 feet high, 10 feet wide, and
10 feet deep. The structure is built with concrete and
is about 10 feet high, 10 feet wide, and 10 feet deep.



Mass-Transfer Tilt Tube Containing 10 g. of Bi



Three 11/16 inch Diam. Holes 120° Apart Hold 9 inch Lengths of Vycor Tubing

Material : Stainless Steel

Heat Storage Blocks Used In Mass-Transfer Tilt Tube Experiment

Figure 3 Mass Transfer Test Specimens

IV RESULTS

A. Corrosion tests - vanadium by bismuth

1. Chemical analysis

Results of chemical analyses of the bismuth are tabulated in Table II. The mean solubility of vanadium in bismuth for each temperature at which the test was run is plotted in Figure 4. Mean solubility of steel (iron in solution) in bismuth is superimposed for purposes of comparison.

2. Metallographic analysis

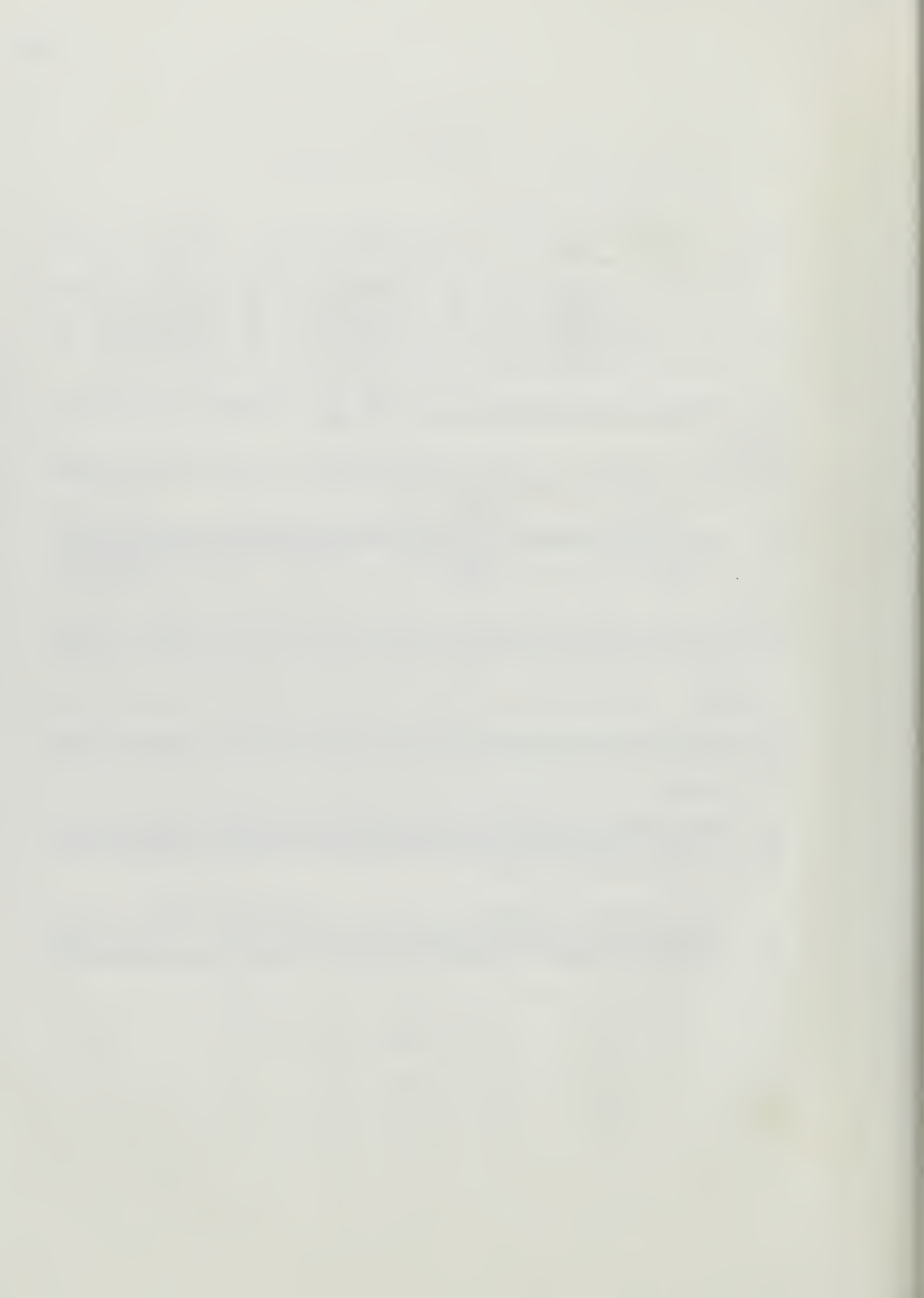
Neither degree of agitation or period in the furnace (shortest period - 24 hours) had significant effect upon final solubility, but did have a marked effect upon the appearance of the attack on the polished interior surface. Figures 5 to 13 are photomicrographs of polished vanadium surfaces following exposure to molten bismuth for the longest and shortest test periods at all test temperatures. Both mild and severe agitation are represented in these photomicrographs.

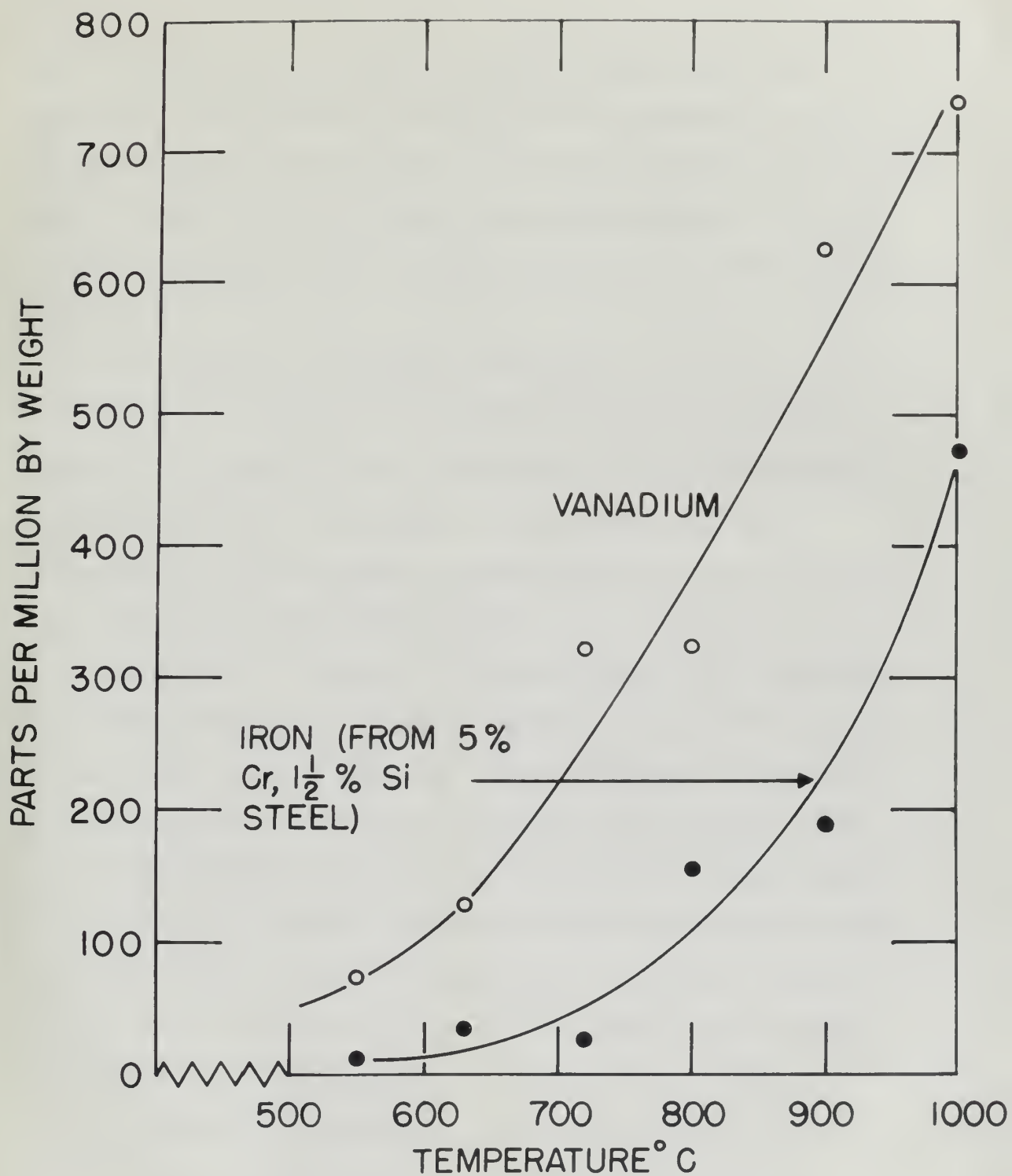
3. Crucible failure

Five crucibles failed under test. Three of these, exposed for 96, 192, and 336 hours, respectively, were at 800° C. All three occupied end positions in the furnace where agitation was most severe. The other two failures occurred at 1000° C when exposed for 144 hours.

CRUCIBLE MATERIAL	LIQUID METAL CONTAINED	TEMPERATURE Degrees C	DURATION OF TEST (Hours)	DEGREE OF ATTACK	CHEMICAL ANALYSIS Crucible in Liquid Metal (%)	TYPE OF ATTACK	DEGREE OF PENETRATION inches x10 ⁻³
Vanadium	Bismuth	550	4	Mild	30		
Vanadium	Bismuth	550	96	Mild	30		
Vanadium	Bismuth	550	218	Mild	220		
Vanadium	Bismuth	550	360	Mild	220		
Vanadium	Bismuth	550	24	Intermediate	30		
Vanadium	Bismuth	550	66	Intermediate	30		
Vanadium	Bismuth	550	218	Intermediate	30		
Vanadium	Bismuth	550	360	Intermediate	30		
Vanadium	Bismuth	550	24	Severe	30	Erosion pits	0.5
Vanadium	Bismuth	550	66	Severe	30		
Vanadium	Bismuth	550	318	Severe	140		
Vanadium	Bismuth	550	360	Severe	140		
Vanadium	Bismuth	550	66	Mild	30	Erosion pits	.75
Vanadium	Bismuth	630	66	Severe	130	Erosion plus	
Vanadium	Bismuth	630	66	Severe	110	Intergranular	1.8
Vanadium	Bismuth	720	66	Mild	360	Intergranular	2.0
Vanadium	Bismuth	720	66	Severe	270	General surface	0
Vanadium	Bismuth	800	24	Mild	710	Erosion	.6
Vanadium	Bismuth	800	48	Mild	260	General surface	0
Vanadium	Bismuth	800	66	Mild	270		
Vanadium	Bismuth	800	102	Mild	370		
Vanadium	Bismuth	800	336	Mild	390		
Vanadium	Bismuth	800	24	Intermediate	140	General surface	0
Vanadium	Bismuth	800	48	Intermediate	360		
Vanadium	Bismuth	800	96	Intermediate	340		
Vanadium	Bismuth	800	192	Intermediate	270		
Vanadium	Bismuth	800	336	Intermediate	340		
Vanadium	Bismuth	800	24	Severe	250	Small erosion	0.4
Vanadium	Bismuth	800	48	Severe	460	Erosion pits	0.4
Vanadium	Bismuth	800	96	Severe	failed		
Vanadium	Bismuth	800	192	Severe	failed		
Vanadium	Bismuth	800	336	Severe	failed		
Vanadium	Bismuth	900	96	Mild	580		
Vanadium	Bismuth	900	96	Severe	580-640	Intergranular	3.0
Vanadium	Bismuth	1000	24	Mild	900	Intergranular	4.5
Vanadium	Bismuth	1000	72	Mild	800-920	Intergranular	1.8
Vanadium	Bismuth	1000	144	Mild	failed	Intergranular	4.5
Vanadium	Bismuth	1000	24	Severe	960		
Vanadium	Bismuth	1000	72	Severe	580-950	Intergranular	1.5
Vanadium	Bismuth	1000	144	Severe	failed	Intergranular	2.3
Vanadium	Bismuth	1000	24	Severe	15	No attack	0
Vanadium	Bismuth	1000	96	Severe	12		
Vanadium	Bismuth	1000	218	Severe	11		
Vanadium	Bismuth	1000	360	Severe	12		
Vanadium	Bismuth	1000	96	Severe	22		
Vanadium	Bismuth	1000	96	Severe	22		
Vanadium	Bismuth	1000	24	Severe	38		
Vanadium	Bismuth	1000	48	Severe	183		
Vanadium	Bismuth	1000	96	Severe	235		
Vanadium	Bismuth	1000	192	Severe	175		
Vanadium	Bismuth	800	336	Severe	173		
Vanadium	Bismuth	900	96	Severe	188	Slight surface roughness	0.1
Vanadium	Bismuth	1000	24	Severe	742	Subsurface voids	0.75
Vanadium	Bismuth	1000	72	Severe	305		
Vanadium	Bismuth	1000	144	Severe	846		
Vanadium	Sodium	550	24	Intermediate	4300	Subsurface voids	3.0
Vanadium	Sodium	550	96	Intermediate	16700	Erosion pits	0.4
Vanadium	Sodium	550	218	Intermediate	10900		
Vanadium	Sodium	550	360	Intermediate	10900		
Vanadium	Sodium	800	24	Intermediate	3900		
Vanadium	Sodium	800	48	Intermediate	4900		
Vanadium	Sodium	800	96	Intermediate	9500		
Vanadium	Sodium	800	192	Intermediate	7300		
Vanadium	Sodium	800	336	Intermediate	6100	Erosion pits	0.4

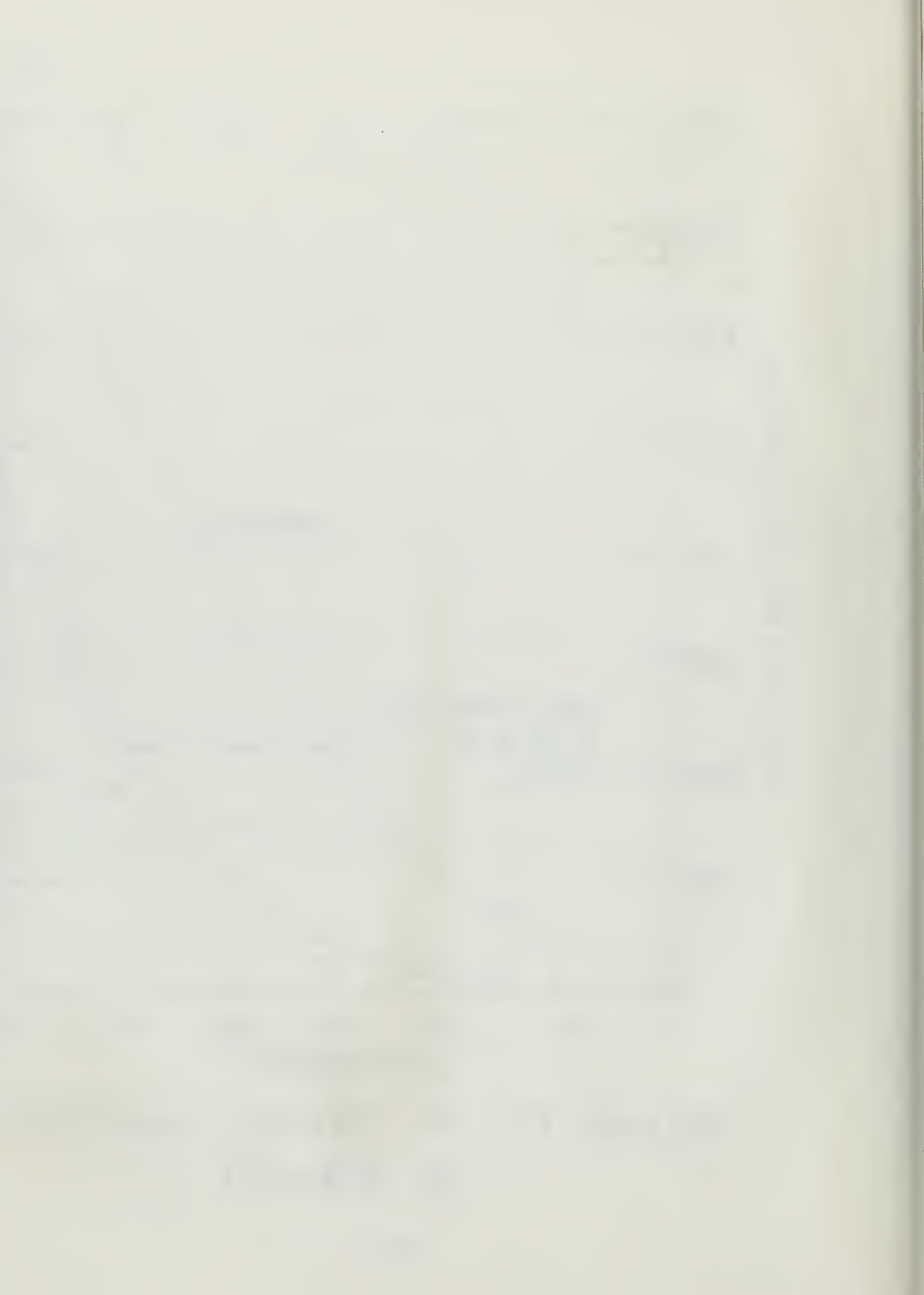
TABLE II. Corrosion test data sheet





SOLUBILITY OF CRUCIBLE MATERIAL IN BISMUTH

Figure 4



One of these two occupied a central (least agitated) position. No intermediate-agitation specimens were included in the 1000°C runs. No steel crucibles failed under test. Steel crucibles always occupied positions of most severe agitation at all temperatures and for all periods tested.

4. Wetting of crucible surfaces

Wetting of the surface in liquid-metal-cooling is considered very important to heat transfer by some authors (4). Although its importance, in the presence of pure material, is disputed, type and thoroughness of wetting were recorded.

Below 700°C wetting of the vanadium by the bismuth was intermittent, the cohered bismuth being in the form of small beads loosely adherent to the surface. At 700°C film formation was evident but still intermittent, the film differing in color from the two metals from which it was formed. Between 700°C and 800°C clear patches of vanadium still appeared occasionally through the film. Above 800°C wetting was thorough - a thick film forming which was quite inseparable from the crucible sides.

In contrast, wetting in the steel crucibles did not appear below temperatures of 800°C and did not exhibit a high degree of adherence to the surface even in the 1000°C specimens. Such wetting as there was in the steel crucibles was entirely different in nature from that in vanadium crucibles.

...is considered very important to meet demands for
new energy (g). Although its importance, in the
process of our country, is discussed, type and quantity
of oil will be required.

[illegible]

B. Corrosion test - Orclor 5 Si by bismuth

Results are included in Table II. Photomicrographs of crucible inner surface attack are collected in Figure 14. Steel surfaces resisted attack far better than did the vanadium at all temperatures. Corrosion was relatively minor until very high temperatures were reached. Above 900°C . the steel was attacked in a peculiar way. Bismuth penetrated through a small fissure in the surface, dissolving away material at the bottom of the fissure to form a pocket or sub-surface void.

C. Corrosion tests - vanadium by sodium

Results are included in Table II. Photomicrographs of crucible inner surface attack are collected in Figure 15. Agitation was intermediate in all cases. Although results of chemical analysis are listed as parts of vanadium per million parts, by weight of sodium, this is by no means intended to portray solubility. All vanadium removed from inner surfaces of the crucible, including entrained particles eroded from the surface as well as vanadium taken into solution by the sodium, was included in the measurement.

D. Mass transfer tests

1. Physical evidence

Photographs of deposited material in the cold end of the tilt-tubes for cycling periods of 168 hours, and 336 hours are shown in Figure 16. Brittleness and fragility of the deposit caused loss and breakage in attempts to polish

1. The first part of the report is devoted to a general survey of the situation in the country. It is divided into three main sections: (a) the political situation, (b) the economic situation, and (c) the social situation. In the first section, the author discusses the recent developments in the political life of the country, including the election of a new government and the role of the various political parties. In the second section, the author examines the state of the economy, particularly the agricultural sector, which is the backbone of the country's economy. He also touches upon the industrial sector and the services sector. In the third section, the author looks at the social conditions, including the level of education, health care, and housing. The second part of the report is devoted to a detailed analysis of the political situation. It discusses the role of the various political parties, the functioning of the government, and the relationship between the government and the people. The author also discusses the role of the judiciary and the media. The third part of the report is devoted to a detailed analysis of the economic situation. It discusses the state of the agricultural sector, the industrial sector, and the services sector. The author also discusses the role of the government in the economy and the impact of international trade. The fourth part of the report is devoted to a detailed analysis of the social situation. It discusses the level of education, health care, and housing. The author also discusses the role of the government in social development and the impact of international aid. The report concludes with a series of recommendations for the government and the people. These recommendations are based on the findings of the report and are intended to guide the government and the people in their efforts to improve the country's situation.

the sections in several instances. There was nothing whatever in the cold end of the tube cycled for only one hour.

Deposit in the cold end of the tube cycled for 336 hours formed a pocket which trapped some of the liquid metal. The entrapped bismuth is clearly seen between the side of the vanadium tube and the deposited material in Figure 16 (b). A photomicrograph of the identical region may be seen in Figure 20. A photomicrograph of the deposit in the 168 hour test is shown in Figure 19 and a macrophotograph of this deposit is included in Figure 16 (a). The high temperature ends of the tubes which were cycled for 1, 168, and 336 hours are shown in Figure 17.

2. Chemical analysis

Chemical analysis of the deposited material from the low temperature ends of the tilt tubes are listed in Table III. The composition of the phases and the relative amounts of each present are not revealed by chemical analysis. The deposited material was loosely bonded to the tube walls and easily broken free.

3. Metallographic examination

Figure 18 is a collection of photomicrographs of the high temperature ends of the tilt-tubes showing attack by the bismuth. Figures 19 and 20 are photomicrographs of the deposit in the cold end showing the microstructure.

4. X-ray spectrographic analysis

In addition to characteristic lines of vanadium and bismuth, two strong lines of an unidentified substance are present in the X-ray spectrograph of the 168 hour cold end

The position in several instances. There was nothing new-
was in the end of the first series the same was found.
Deposit in the end of the first series the 150 bones
found a great many bones were of the 150th series. The
entire series is slightly more between the 150th and the
150th series and the 150th series is 150th series.
A photograph of the 150th series was in
Figure 10. A photograph of the 150th series is in the
150th series is 150th series and a photograph of this
series is included in Figure 10. The 150th series
was of the 150th series was 150th series, and 150th series
are shown in Figure 10.

2. General results

General results of the 150th series
From the 150th series was of the 150th series was 150th series
Figure 10. The 150th series of the 150th series and the 150th series
series is 150th series and was 150th series by 150th series.
The 150th series was 150th series, 150th series in the 150th series
and 150th series was 150th series.

3. Results of the 150th series

Figure 10 is a photograph of the 150th series of
the 150th series was of the 150th series was 150th series by
the 150th series. Figure 10 and 150th series of the
series in the 150th series was 150th series.

4. Results of the 150th series

In addition to the 150th series of the 150th series
and 150th series, the 150th series of the 150th series was 150th series
series in the 150th series was 150th series and 150th series

Duration of test (hours)	Temperature of hot end (degrees C)	Temperature of cold end (degrees C)	Frost Liquid Metal Remaining (per cent)	Chemical Analysis of cold end deposit
1	900	300	98	no deposit
168	900	390	35	3.06% vanadium 96.94% b1 smooth
336	900	320	8	6.25% vanadium 93.75% b1 smooth
500	900	300	2	4.65% vanadium 93.35% b1 smooth

TABLE III Data on Mass Transfer Test

altered looking - low light to - change	Low light level - 100 lux - 100 lux	medium - 100 lux - 100 lux	high - 100 lux - 100 lux	medium - 100 lux - 100 lux	high - 100 lux - 100 lux
100 lux	100 lux	100 lux	100 lux	100 lux	100 lux
100 lux	100 lux	100 lux	100 lux	100 lux	100 lux
100 lux	100 lux	100 lux	100 lux	100 lux	100 lux
100 lux	100 lux	100 lux	100 lux	100 lux	100 lux

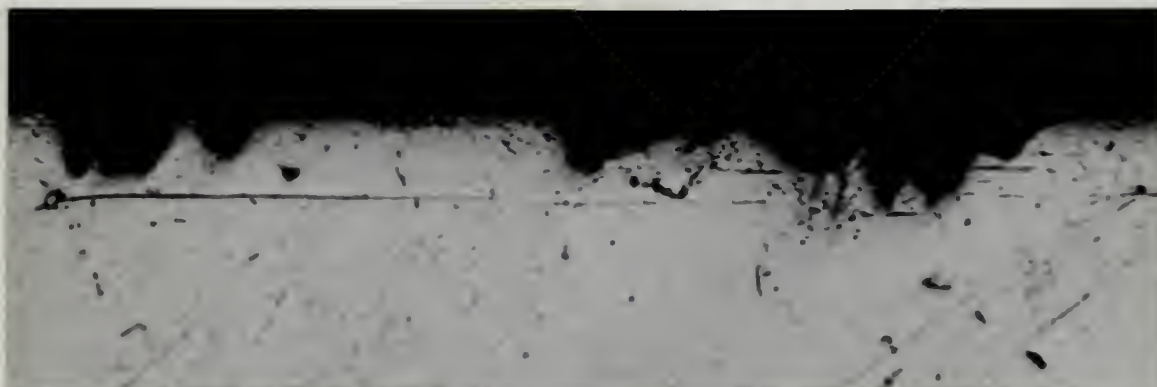
low light level - 100 lux

deposit. A vanadium-bismuth alloy is clearly indicated. Since extra lines introduced by this alloy are so few, probable existence of a cubic phase is inferred.



(a)

Temperature : 550°C
Period : 24 hours
Agitation : mild



(b)

Temperature : 550°C
Period : 24 hours
Agitation : severe

Figure 5

Cross section of interior surface of vanadium crucibles containing bismuth. Etched. Magnification 600x.

W-100-005-A

TEMPERATURE :
PRESSURE :
WIND :
WAVE :
WAVE PERIOD :

(4)

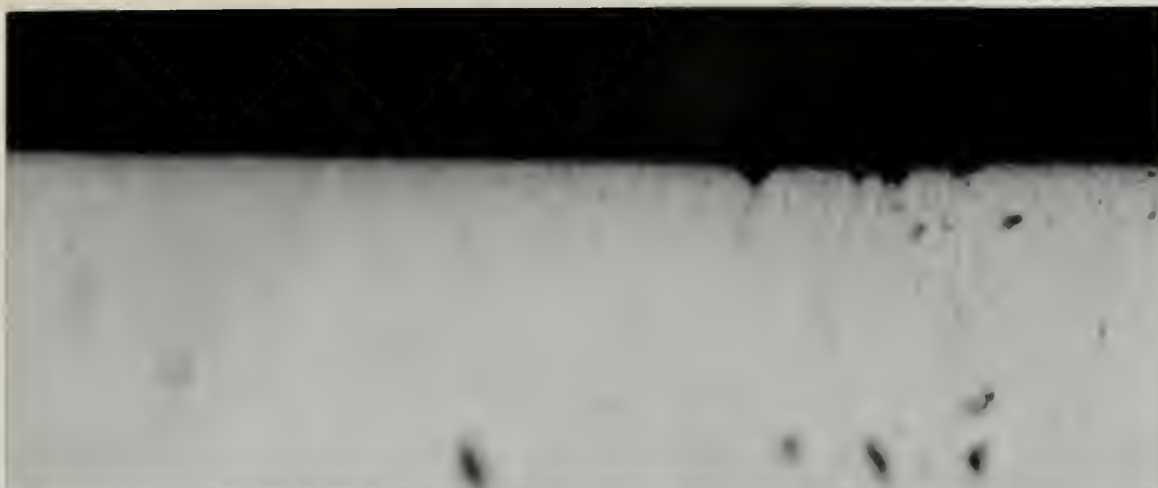
W-100-005-A

TEMPERATURE :
PRESSURE :
WIND :
WAVE :
WAVE PERIOD :

(5)

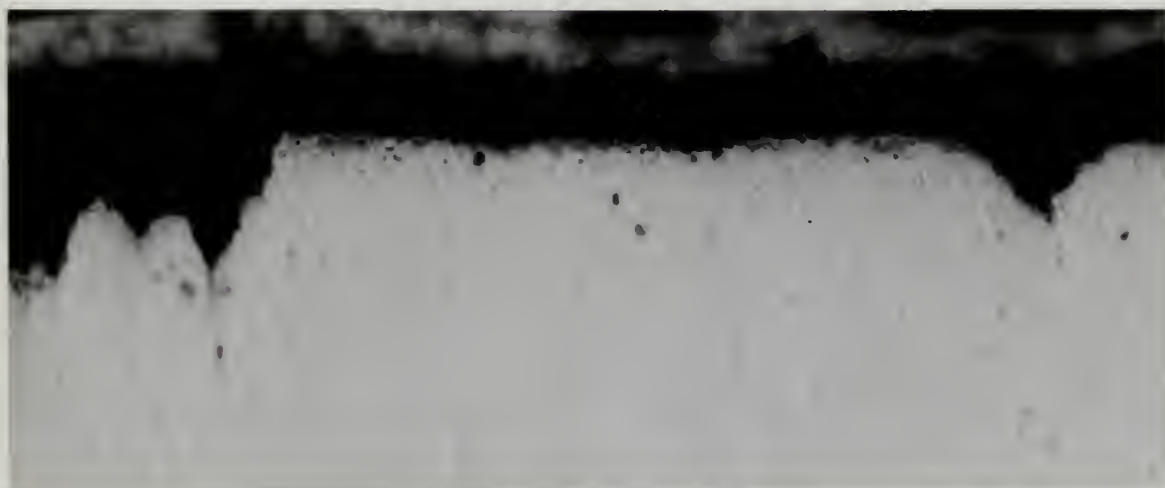
2000

These values are for the purpose of the report only. They are not to be used for any other purpose.



(a)

Temperature : 550°C
Period : 360 hours
Agitation : mild



(b)

Temperature : 550°C
Period : 360 hours
Agitation : severe

Figure 6

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 600X.

Temperature : 25°C
 Period : 100 hours
 Activation : mild

(a)

Temperature : 25°C
 Period : 100 hours
 Activation : severe

(b)

Figure 2

Gross section of interior surface of ammonia crystals containing
 bromine. Unetched. (X100).



(a)

Temperature : 630°C
 Period : 96 hours
 Agitation : mild



(b)

Temperature : 630°C
 Period : 96 hours
 Agitation : severe

Figure 7

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 600X.

1. 1000
 2. 1000
 3. 1000

(a)

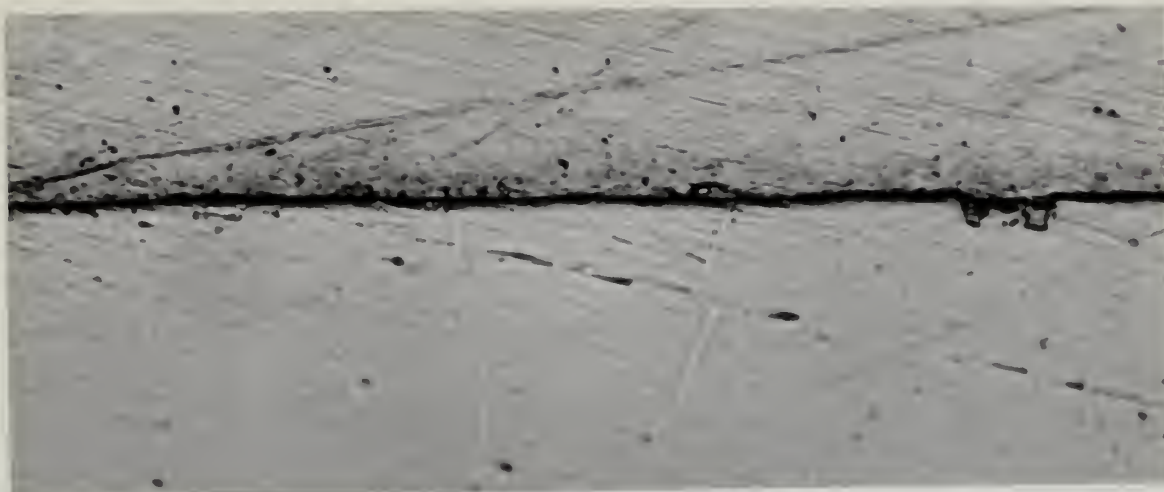
5-24-03-1

1. 1000
 2. 1000
 3. 1000

(b)

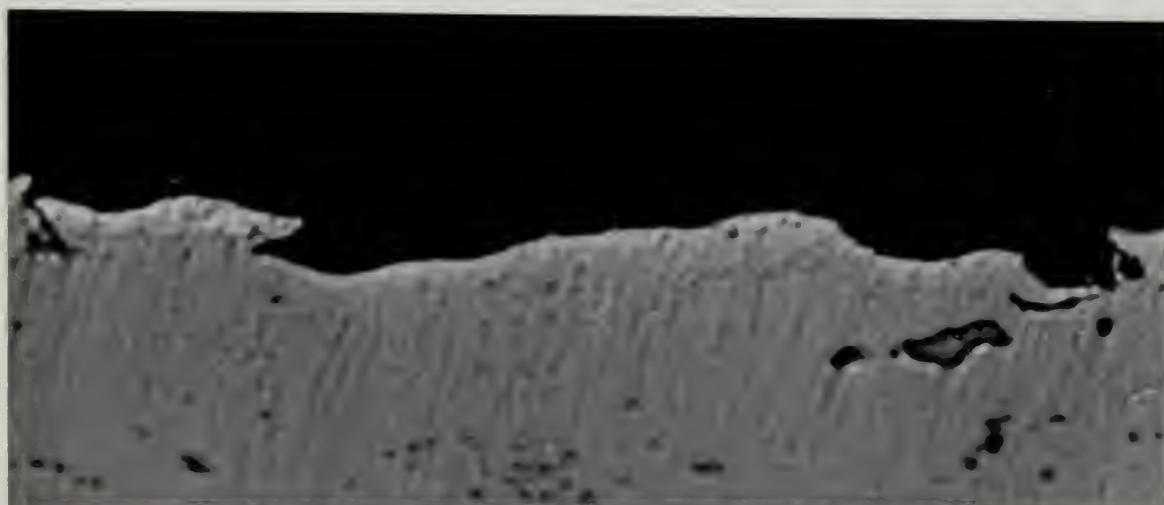
Yours

This letter is to inform you that the enclosed letterhead of the United States
 Government is being used for the purpose of the enclosed letterhead.



(a)

Temperature : 720°C
 Period : 96 hours
 Agitation : mild



(b)

Temperature : 720°C
 Period : 96 hours
 Agitation : severe

Figure 5

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 600X.

Y-480-78-4

Temperature : 70°
 Volume : 100 ml
 Solution : 100 ml

(a)

Y-480-78-5

Temperature : 70°
 Volume : 100 ml
 Solution : 100 ml

(b)

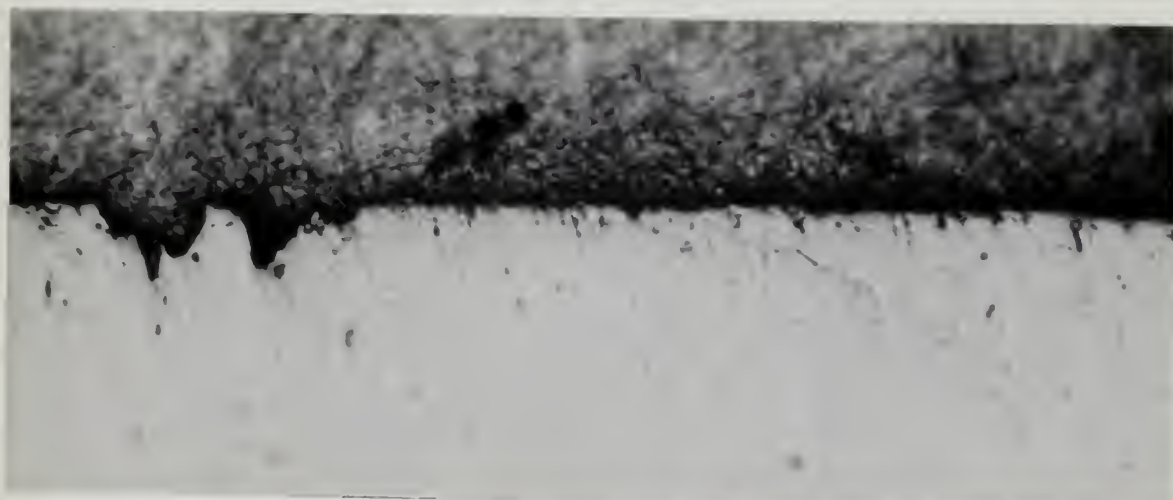
Figure 2

These results of isotherm studies in various solvents are summarized in Table I.



(a)

Temperature : 800°C
 Period : 24 hours
 Agitation : mild



(b)

Temperature : 800°C
 Period : 24 hours
 Agitation : severe

Figure 9

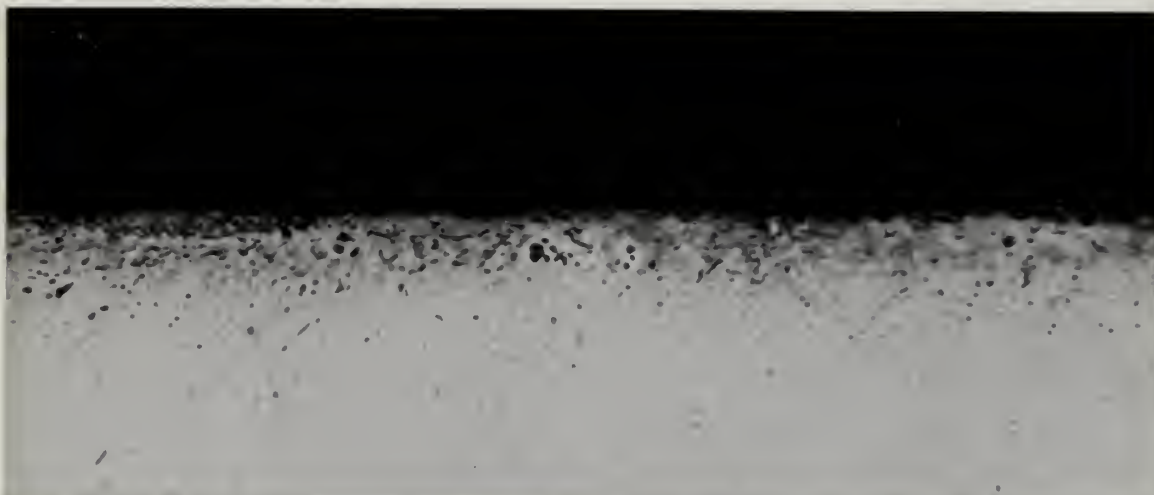
Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 600X.

403

(5)

◎ 杨 明 著

Special section of *Journal of American Studies* 1990, 24, 1, 1-10.



(a)

Temperature : 800°C
 Period : 338 hours
 Agitation : mild



(b)

Temperature : 800°C
 Period : 338 hours
 Agitation : intermediate (substituted for
 severely agitated specimen,
 which failed)

Figure 10

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 600X.

10-252-100-1

1000 : 1000000
1000 : 1000000
1000 : 1000000

(a)

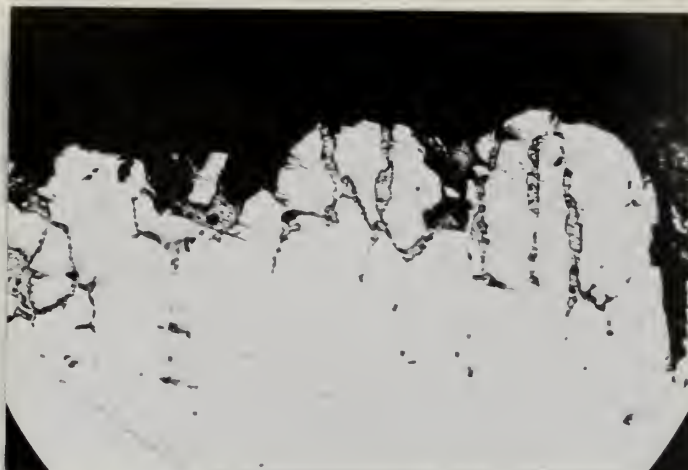
10-252-100-1

1000 : 1000000
1000 : 1000000
1000 : 1000000
1000 : 1000000
1000 : 1000000

(b)

1000 : 1000000

These figures are subject to change without notice. The figures are subject to change without notice. The figures are subject to change without notice.



(a)

Temperature : 900°C
 Period : 96 hours
 Agitation : mild



(b)

Temperature : 900°C
 Period : 96 hours
 Agitation : severe

Figure 11

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 300X.

Temperature : 20°C
 Period : 24 hours
 Altitude : 1114

(a)

Temperature : 20°C
 Period : 24 hours
 Altitude : 1114

(b)

Figure 11

Notes: Section of Interior surface of concrete structure containing
 pipes, located, Section 1001.



(a)

Temperature : 1000°C
 Period : 24 hours
 Agitation : mild



(b)

Temperature : 1000°C
 Period : 24 hours
 Agitation : severe

Figure 12

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 300X.

1000 : 1000
 1000 : 1000
 1000 : 1000

(a)

1000 : 1000
 1000 : 1000
 1000 : 1000

(b)

1000

1000 : 1000
 1000 : 1000



(a)

Temperature : 1000°C
 Period : 72 hours
 Agitation : mild

Note: 72-hour specimen substituted for
 144-hour specimen which failed under test.



(b)

Temperature : 1000°C
 Period : 72 hours
 Agitation : severe

Note: 72-hour specimen substituted for
 144-hour specimen which failed under test.

Figure 13

Cross section of interior surface of vanadium crucibles containing bismuth. Unetched. Magnification 300X.

(a)

Temperature : 1000°
Period : 15 hours
Atmosphere : Air

Note: The test specimen was subjected for 14-hour exposure under test.

(b)

Temperature : 1000°
Period : 15 hours
Atmosphere : Air

Note: The test specimen was subjected for 14-hour exposure under test.

Figure 15

Cross section of interior surface of specimen containing plasma. (Inverted. Magnification 100x).



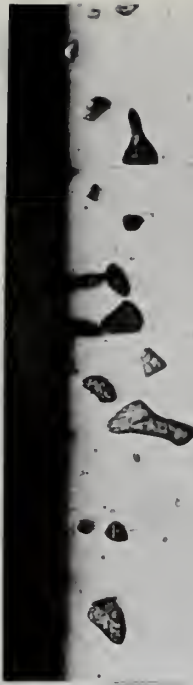
(a) Temperature : 550°C
Period : 24 hours
Agitation : severe



(b) Temperature : 500°C
Period : 24 hours
Agitation : severe



(c) Temperature : 800°C
Period : 336 hours
Agitation : severe



(d) Temperature : 1000°C
Period : 24 hours
Agitation : severe

(e) Temperature : 1000°C
Period : 144 hours
Agitation : severe

Figure 14

Cross section of interior surface of steel (Croloy 5 Si) crucibles containing bismuth. Unetched.
Magnification 300X.

(continued)

1. The first group of authors (e.g., [1, 2]) considers the problem of the stability of the motion of a system of particles in the field of a central body. The results of the calculations show that the motion of the particles is stable for a wide range of initial conditions. The authors also show that the motion of the particles is stable for a wide range of initial conditions.

2

[illegible]

2

1. 1000
 2. 1000
 3. 1000

100

1	100	100
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100	100	100

6

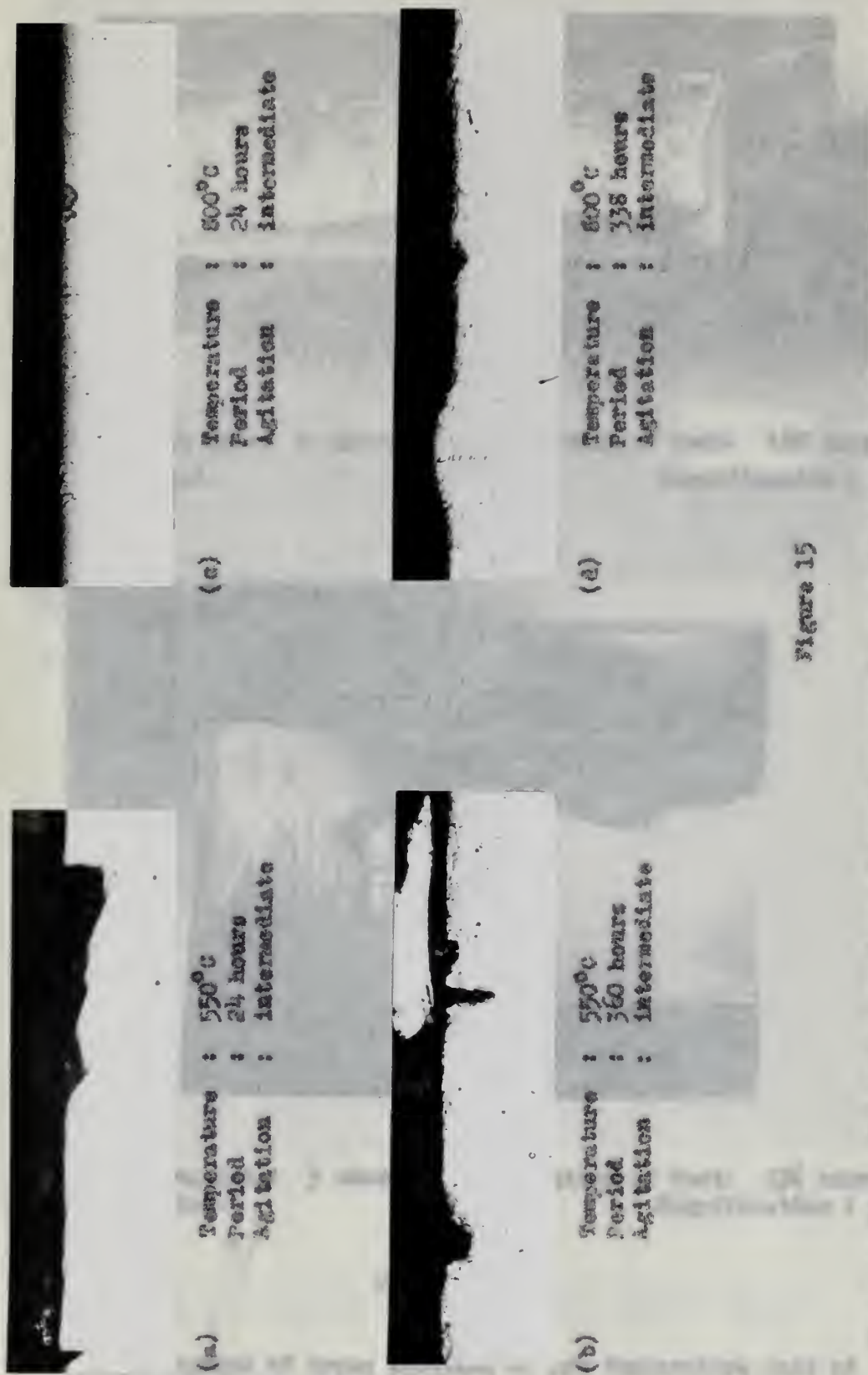


Figure 15

Cross section of interior surface of vanadium crucibles containing sodium. Untetched. Magnification 300X.

$\frac{1}{2} \log$: $\frac{1}{2} \log$
 actual : actual
 observed : observed

(1)

$\frac{1}{2} \log$: $\frac{1}{2} \log$
 actual : actual
 observed : observed

(2)

$\frac{1}{2} \log$: $\frac{1}{2} \log$
 actual : actual
 observed : observed

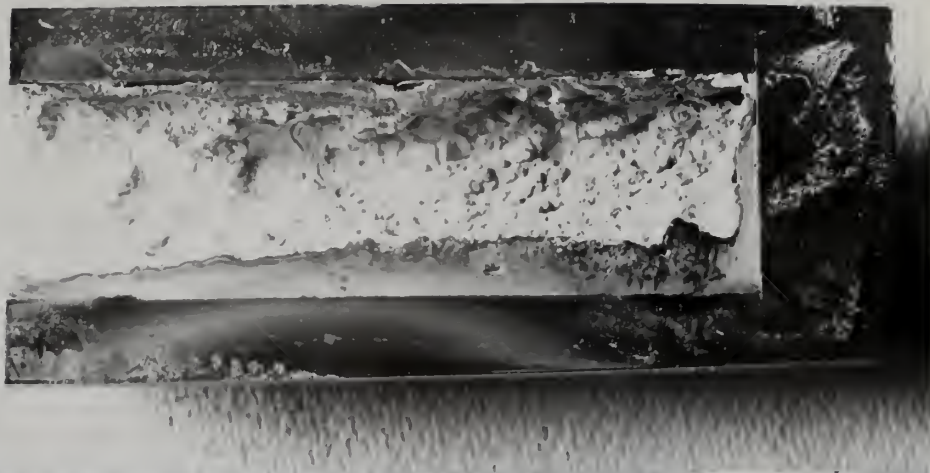
(3)

$\frac{1}{2} \log$: $\frac{1}{2} \log$
 actual : actual
 observed : observed

(4)

TABLE

The following table shows the results of the analysis of variance for the data presented in the preceding pages.



(a) Cycling Rate: 5 minutes.
Unetched.

Duration of Test: 168 hours.
Magnification: 4X



(b) Cycling Rate: 5 minutes.
Unetched.

Duration of Test: 336 hours.
Magnification: 6X

Figure 16

Macrograph of cross sections of low temperature ends of mass transfer tilt tubes.



(a) one
hour

(b) 168
hours

(c) 336
hours

Figure 17

Macrophotographs of high temperature ends of tilt tubes cycled for 1, 168, and 336 hours. Unetched. Magnification: 3X.

(a) Unetched end of tilt tube after 1 hour.

Figure 18

Unetched end of tilt tube after 168 hours of cycling. Magnification: 3X.

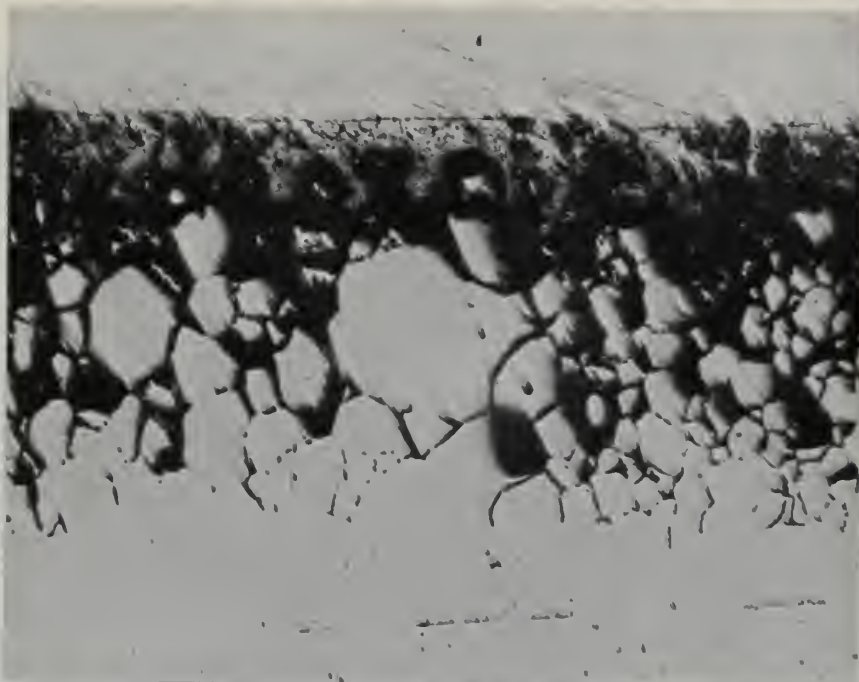
(a) 220
hours

(b) 100
hours

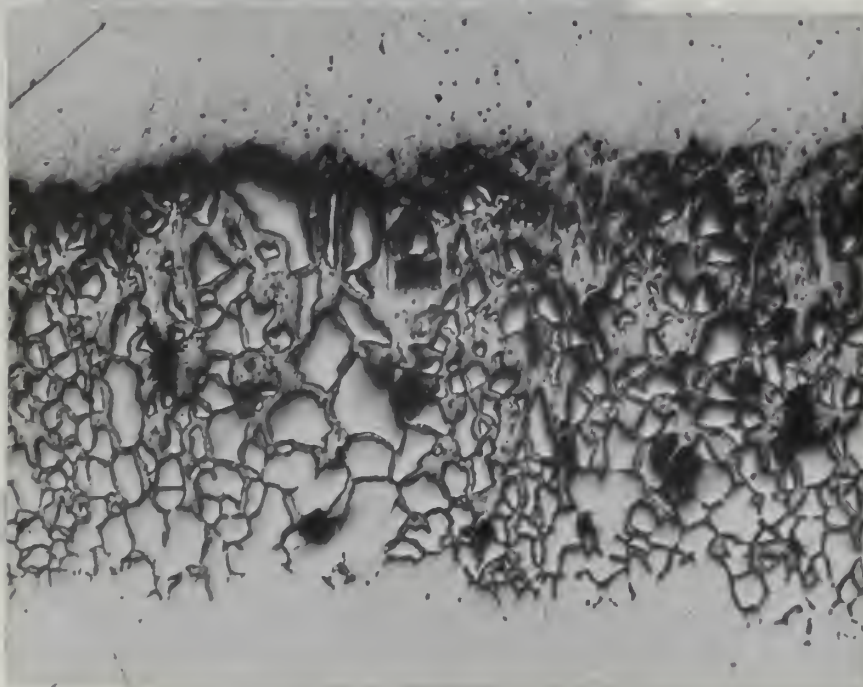
(c) 500
hours

Figure 17

Microphotographs of high temperature tests of Silex tubes tested for 1, 100, and 500 hours. (a) 100 hours. (b) 100 hours. (c) 500 hours.



(a) Duration of Test: 168 hours.



(b) Duration of Test: 336 hours.

Figure 18

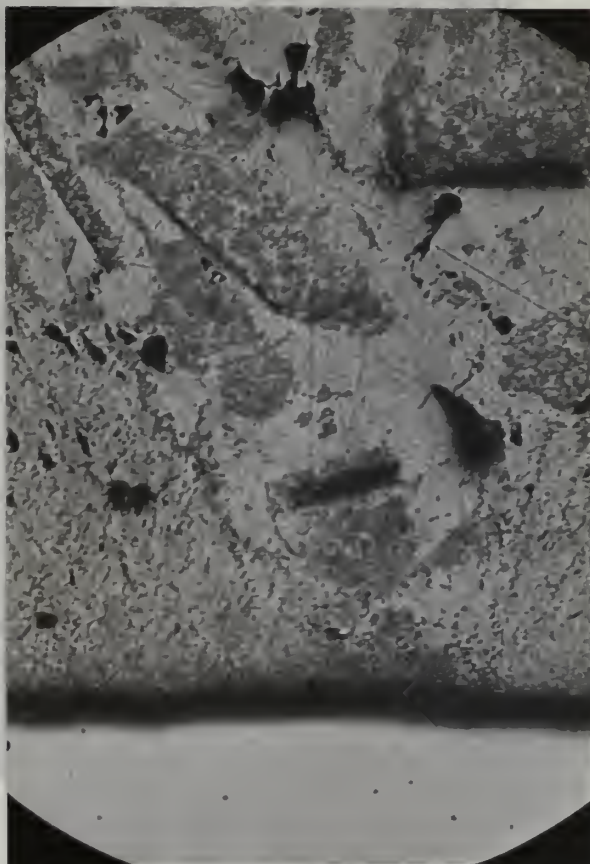
Cross section of high temperature ends of mass-transfer
tilt tubes. Unetched. Magnification: 150X.

(a) Duration of test: 100 hours.

(b) Duration of test: 100 hours.

Figure 18

These sections of high temperature rods of annealed
 100% nickel. Location: 100% nickel.



Material
deposited
in
cold end
of
tilt tube.

Vanadium

Figure 19

Photomicrograph of deposit in low temperature end of tilt tube.
Duration of Test: 168 hours. Unetched. Magnification: 90X.

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101100.

Author: B. L. Evans

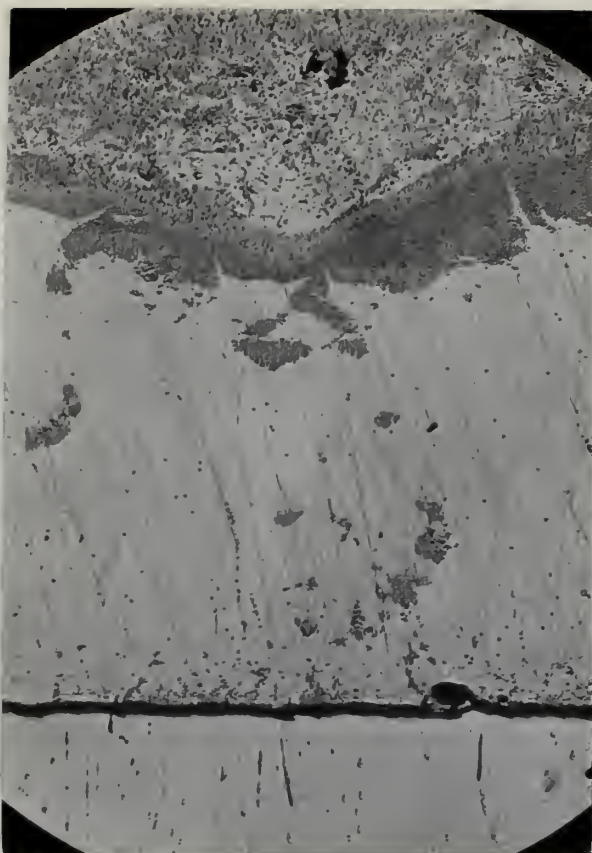
48

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25 451,17

For the purpose of this report, the following information was obtained from the records of the Department of the Interior, Bureau of Land Management, and the Bureau of Reclamation, and from the records of the various landowners and lessees of the land in question.



Material deposited
in
cold end of tube.

Entrapped

Liquid

Metal

Vanadium

Figure 20

Photomicrograph of deposit in low temperature end of tilt tube.
Duration of Test: 336 hours. Unetched. Magnification: 90X

[illegible]

V. DISCUSSION OF RESULTS

A. Corrosion tests

1. Solubility tests

The solubility of iron in molten bismuth was low up to about 750°C above which it is seen to increase rapidly as shown in Figure 4. The vanadium solubility curve, within the temperature range tested, exhibits much greater linearity, not having a particular temperature above which corrosion accelerates rapidly. Neither, on the other hand, does it have a temperature region in which its solubility characteristics may be considered good. The almost linear increase of solubility with temperature establishes conditions favorable to thermal gradient mass transport at any selected set of operating temperatures. Solubility of vanadium in bismuth was greater than that of iron in bismuth at all temperatures tested.

2. Corrosion and corrosion-erosion

Marked difference in surface attack at low temperatures are evident (Figures 5 and 6) between specimens which had gentle agitation and those which had severe agitation. At first, attack increases as temperature is increased, showing definite intergranular attack at 630°C (Figure 7). However, intergranular attack diminishes at the temperatures at which intermetallic film formation becomes manifest. At 720°C , one of the specimens shows film formation with adherent bismuth. The other did not form a film and

Source: *Journal of the American Statistical Association*, 1997, 92, 1031-1042.

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was corroded (Figure 5). At 800° C intermetallic film formation was fairly consistent and the surfaces were only slightly damaged. At 900° C and above, intense intergranular attack again becomes evident, reaching proportions of 500 mils per year at 1000° C. Measurements of penetration at these temperatures is rather arbitrary since damage is often so advanced as to make the location of the original surface level a matter of conjecture. Attack, at 1000° C, appears more severe for specimens agitated mildly than for highly agitated specimens. This may be caused by mechanical breaking away, under severe agitation, of grains whose boundaries have been chemically attacked, giving the appearance of less penetration.

B. Corrosion-erosion of vanadium by sodium

Corrosion at low temperature is again evident though generally to a lesser degree than that caused by bismuth. Attack was worse at 550° C than at 800° C, amounting to 197,000 parts per million at 550° in 360 hours. The surfaces at 800° are characterized by bumps or protuberances. These bumps are believed to be localized points resistive to corrosion attack, possibly due to impurities present. Attack is believed to be a general surface attack, leaving the resistive points salient from the lowered surface.

Though this set of tests are of a rough and possibly inconclusive nature, it appears that vanadium does not hold such promise as a container material for molten sodium.

[illegible]

C. Thermal gradient mass transport tests

Evidence of mass transfer under the extreme conditions imposed in this test is incontrovertible. After completion of the tests it was evident that more bismuth should have been introduced into the mass-transfer tubes. Upon sectioning the tube after a test period of 336 hours, almost all bismuth was depleted (see Figure 17). A large proportion of it had apparently gone into a stalagmitic growth in the center of the tube adhering to the lower side and to the end. The growth was brittle and of a very fragile nature and was broken in attempting to prepare it for photographing. A considerable portion of the bismuth had apparently gone into a gold-colored layer adhering to the walls of the tube beginning at about the center of the tube and becoming quite thick at the high temperature end. The appearance of the film may be noted in Figure 17.

Corrosion attack of the prepared surface at the hot end of the mass transfer tubes was intergranular in nature and was so severe for the cycling periods of 168 and 336 hours that the lowest power available in the microscope barely included the full depth of penetration in its field. There was no apparent attack in the tube operated for only one hour. In the 500 hour test, penetration was visible to the naked eye (about 1.5 Millimeters).

of the first of the series of the first series.

Secondly, it is necessary to note the following:

1. The first of the series of the first series.

2. The second of the series of the first series.

3. The third of the series of the first series.

4. The fourth of the series of the first series.

5. The fifth of the series of the first series.

6. The sixth of the series of the first series.

7. The seventh of the series of the first series.

8. The eighth of the series of the first series.

9. The ninth of the series of the first series.

10. The tenth of the series of the first series.

11. The eleventh of the series of the first series.

12. The twelfth of the series of the first series.

13. The thirteenth of the series of the first series.

14. The fourteenth of the series of the first series.

15. The fifteenth of the series of the first series.

16. The sixteenth of the series of the first series.

17. The seventeenth of the series of the first series.

18. The eighteenth of the series of the first series.

19. The nineteenth of the series of the first series.

20. The twentieth of the series of the first series.

21. The twenty-first of the series of the first series.

22. The twenty-second of the series of the first series.

23. The twenty-third of the series of the first series.

24. The twenty-fourth of the series of the first series.

VI CONCLUSIONS

A. Commercial quality high-ductility vanadium is not a suitable container material for high purity molten bismuth because of the following demonstrated properties:

1. low resistance to mechanical attack at temperatures between 550 and 700°C
2. High solubility in molten bismuth
3. severe inter-granular corrosion at high temperatures
4. susceptibility to thermal gradient mass transport. (Convection currents of bismuth in a vanadium circuit may be expected to produce plugging in the cold portion of the loop and severe attack in the hot portion).

B. Commercial quality vanadium shows little promise as a container material for molten sodium.

VI. CONCLUSIONS

1. The proposed method is a simple and efficient way of determining the relative positions of the various components of a system.
2. The method is applicable to systems of any size and complexity.
3. The method is applicable to systems of any type and structure.
4. The method is applicable to systems of any kind and nature.
5. The method is applicable to systems of any form and shape.
6. The method is applicable to systems of any color and texture.
7. The method is applicable to systems of any sound and smell.
8. The method is applicable to systems of any taste and touch.
9. The method is applicable to systems of any feeling and thought.
10. The method is applicable to systems of any action and reaction.

VII RECOMMENDATIONS

The light weight, abundance, high strength-weight ratio, high-temperature strength, and reasonable fabrication characteristics (5, 6), coupled with a small neutron absorption cross-section (2) make vanadium a highly desirable material for use in nuclear reactors, (particularly in fast reactors). In order to evaluate its feasibility for use in a fast homogeneous reactor further research, using the techniques of the foregoing experiments, could be continued along three general lines:

1. evaluation of vanadium alloys, such as a vanadium-2% zirconium alloy (2), as container materials for bismuth
2. evaluation of pure vanadium and vanadium alloys as container materials for other easily-liquified metals which have low neutron absorption cross sections, such as gallium, lead, lithium, thallium, tin, and low-melting eutectics of lead-bismuth (3)
3. evaluation of inhibitors, such as zirconium and magnesium, in a vanadium bismuth system to eliminate the selective attack at the grain boundaries and reduce the rate of solution.

Appendix A

Furnace Design and Construction

Design parameters for the furnace were imposed by an unusual set of circumstances dictated by the testing procedure decided upon. Because of the shocks and mechanical stresses to which the furnace would be subjected, it was imperative that the windings be exceptionally rugged. The physical size of the furnace had to be fairly small so that the test-board dimensions would be reasonable, yet the isothermal region within the furnace had to be relatively large. The latter criterion necessitated multiple windings with the individual windings controllable independently. In the presence of a constant-power-per-turn winding, temperature in this type of furnace usually distributes itself along a cosine curve on the longitudinal axis because of the maximum heat loss to the ends of the core. To compensate for this, windings were designed with maximum power per turn at the ends and minimum at the center. For rigidity and high temperature strength, a very heavy wire, twelve gauge was decided upon. The large diameter and low resistance of the wire enforced the use of transformers to provide low-voltage high-power sources. Five zones of controllable heating were decided upon in order to insure that constant temperature could be maintained over a large portion of the furnace length. Since the transformers provided isolation of the power sources, adjacent windings shared lead-in wires and internal wiring was kept to a minimum. The twelve gauge wire was wound on a three inch diameter Aluminum refractory tube, 18 inches in length, grooved

6 turns to the inch. The end windings, consisting of 14 turns each, were energized by 24 volts (nominal voltage). These windings extended no further than the end plugs of the core, and were intended to heat the plugs and prevent heat loss and consequent temperature drop at the ends. The actual interior portion of the furnace was heated by three windings of 22, 34, and 22 turns respectively, energized by voltages (nominal) of 30, 36, and 30 volts. The primary of each isolation and step-down transformer was energized by a Variac variable voltage transformer by which the output voltage could be varied from 0 to 117 % of nominal voltage. A chromel-alumel thermocouple was placed directly adjacent to the center of the winding and used for operation of a Leeds and Northrup Micromax controller. The controller operated a holding type relay (to prevent relay chatter) which, during demand periods, shorted out a large Variac used as a variable inductance in series with all Variacs controlling furnace region isolation transformers. During non-demand periods the voltage to the isolation transformers was reduced by the drop across the series inductance. This method of control was the only one of the three tried which did not result in excessive relay contact arcing due to inductive effects of the five isolation transformers in parallel. A circuit diagram of the furnace winding and control circuit is shown in Figure 21.

Leads from the individual windings were welded to the common points of the windings and consisted of double lengths of 12 gauge wire spot welded together every two inches. Ends of the double wires were welded

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to studs which passed through the transite furnace supports and were used as connection points. Using equal power in all windings (not equal power per turn) the furnace temperature between end plugs was within ten per cent of the center set temperature (maintained by controller) upon first heating. By adjustment of voltage to the individual zones, temperatures within the furnace could be maintained to within plus or minus $1/2\%$ at all points.

The frame for the furnace tester-board (Figure 1) was made using four-inch channel beams and was supported, at first, in brass sleeve bearings. The weight of the furnace caused binding of the sleeve bearings. This interfered with the bouncing action intended to supply severe agitation to the end-mounted specimens. Large ball bearings were substituted for the sleeve bearings and no further bearing difficulty was experienced.

For the corrosion tests the microswitch and operating cam shown Figure 1 were not used. The motor speed controller was set to bounce the furnace on the springs once every 5 seconds.

For the mass transfer tests the bouncing action of the furnace tester-board was damped out, and the oscillation period reduced to a ten minute cycle.

Oscillation frequency was reduced by periodic interruption of power to the motor by an electronic interval timer. The circuit diagram of the interval timer is shown in Figure 22. The cam operated the microswitch as the furnace tester-board went through horizontal dead

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center. The power was then cut off to the motor, but inertia kept the motor going for a few more turns. From this point on the furnace dropped freely onto a damped stop. At the end of the timed interval the intermittent lift action of the operating mechanism allowed the motor to build up to speed under no load conditions.

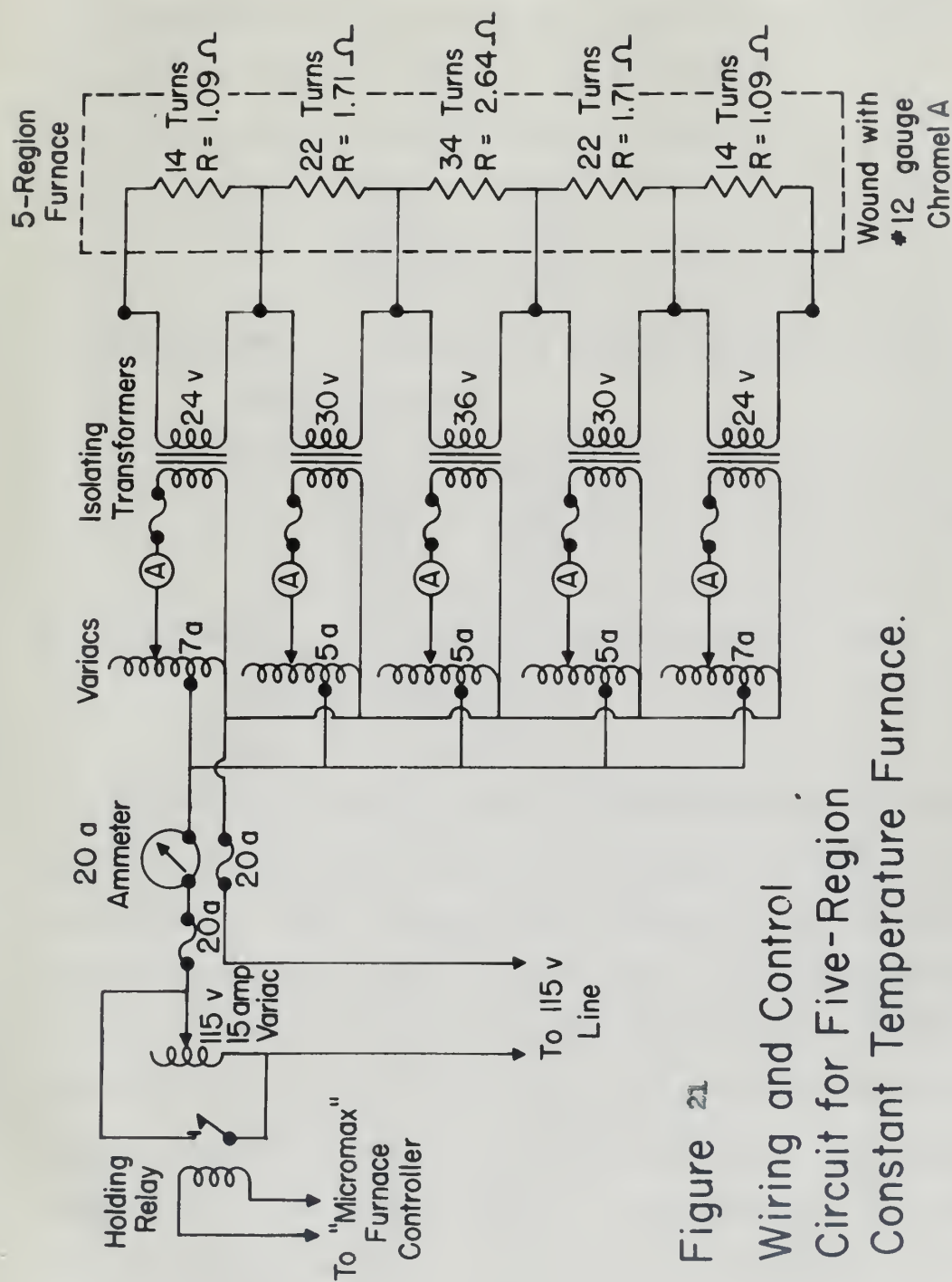
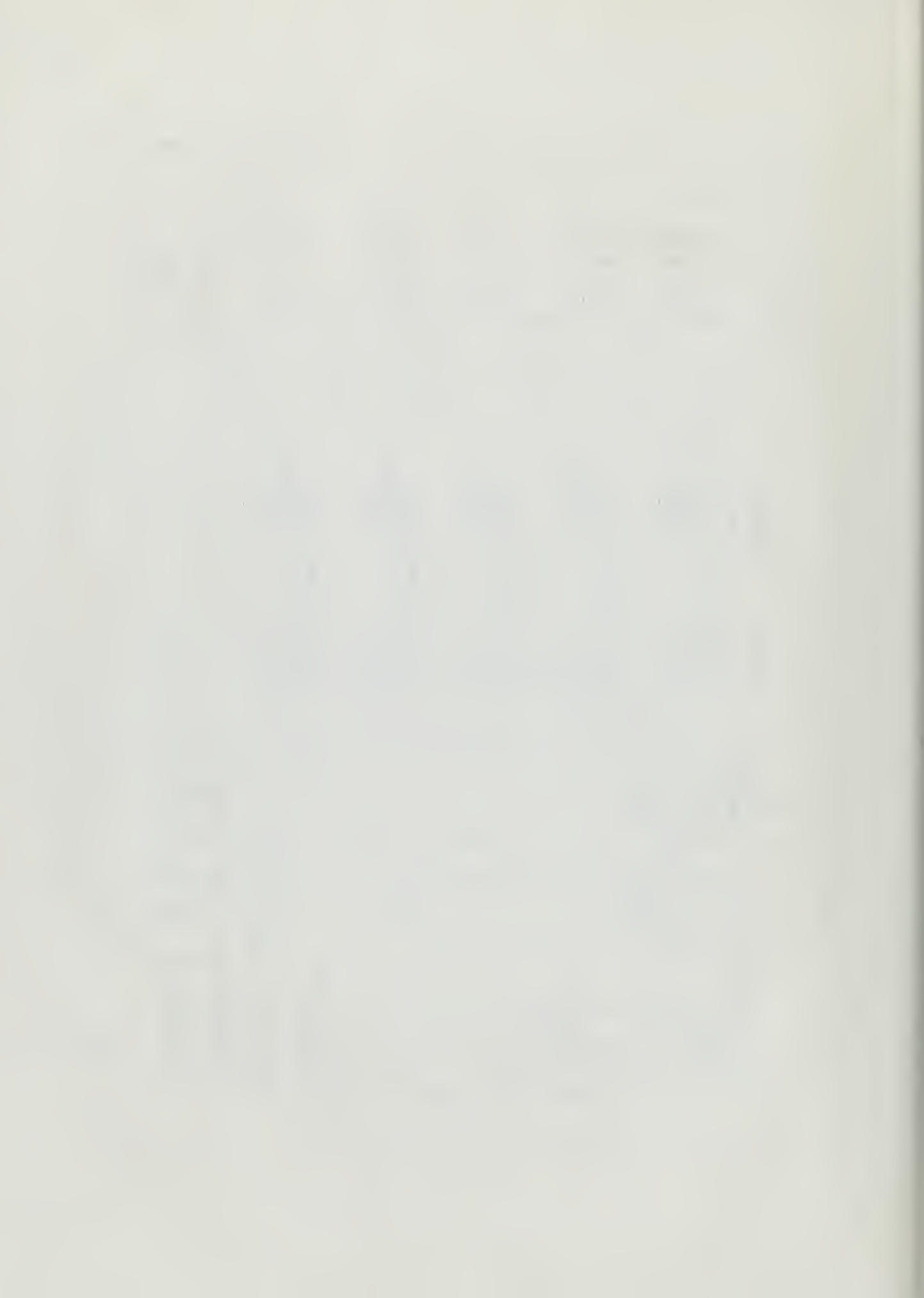


Figure 21
Wiring and Control
Circuit for Five-Region
Constant Temperature Furnace.



APPENDIX B

Crucible Construction, Loading, and Welding

Specifications for the starting materials are as follows:

1. vanadium metal (Electro-Metallurgical Co.)

form: chips, 1/4 inch by 12 mesh

analysis :	carbon	0.05%
	oxygen	0.056%
	hydrogen	0.01 %
	nitrogen	0.06 %

2. bismuth metal (Mallinckrodt Chemical Works)

form : granulated

analysis :	arsenic	0.000 %
	copper	0.005 %
	iron	0.00 %
	silver	0.005 %
	zinc	0.00 %

3. sodium metal (Mallinckrodt Chemical Works)

form : solid billets

analysis : not available

The vanadium metal chips were cold compacted in a steel can at 32,000 pounds per square inch. The can was then evacuated, sealed off and extruded at 1950° F through a 0.7 inch die, the extrusion constant being 64,000 pounds per square inch. The first extrusion was largely unusable because of insufficient back pressure, resulting in cracks and fissures in the rod. Subsequent extrusions were made with a nickel plug at the front of the extrusion billet. The nickel, not being as soft as the steel at 1950° F greatly increased the initial back pressure and resulted in an extrusion of much better quality. The rods were swaged lightly for straightening, then turned down on a lathe to the final outer diameter, thereby removing the steel jacket.

TABLE 2

Grain Production, 1950-1951, and 1952-1953

Grain Production for the 1950-1951 and 1952-1953 seasons

1. Grain Production (in thousands of bushels)

Grain Production (in thousands of bushels)

1950-1951	1952-1953
1,000,000	1,000,000
1,000,000	1,000,000
1,000,000	1,000,000
1,000,000	1,000,000

2. Grain Production (in thousands of bushels)

Grain Production (in thousands of bushels)

1950-1951	1952-1953
1,000,000	1,000,000
1,000,000	1,000,000
1,000,000	1,000,000
1,000,000	1,000,000
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3. Grain Production (in thousands of bushels)

Grain Production (in thousands of bushels)

Grain Production (in thousands of bushels)

The following table shows the grain production in the United States

for the years 1950-1951 and 1952-1953. The data are shown in thousands of bushels.

and are based on the 1950-1951 and 1952-1953 seasons. The data are shown in thousands of bushels.

existing for the 1950-1951 and 1952-1953 seasons. The data are shown in thousands of bushels.

Grain production in the United States for the years 1950-1951 and 1952-1953.

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Grain production in the United States for the years 1950-1951 and 1952-1953.

Grain production in the United States for the years 1950-1951 and 1952-1953.

Discarding the ends of these rods (which were contaminated with nickel at the front and with steel at the back) left a solid vanadium rod. Sectioning of the rods into crucible lengths was followed by the drilling out of each section to proper depth. Interior surfaces were polished with fine emery cloth. Caps for the crucibles were prepared from the same material, the inner surface being given a metallographic polish. Dimensions of the assembled crucible are included in Figure 2. Just prior to charging these crucibles with bismuth metal, they were thoroughly cleaned by pickling in concentrated nitric acid.

It was felt that the metallic bismuth, despite its high purity, should not be placed directly into the vanadium crucibles due to the large surface area in its granulated form and the existence, at room temperature, of an oxide film on bismuth. The surface area was greatly reduced by melting down the granules in a graphite crucible (in air) and pipetting unoxidized metal from below the surface. The metal was drawn up into a 1/4 inch (inner diameter) Pyrex tube and allowed to freeze, after which the glass was broken away and the bismuth rods cut into 4.5 gram lengths. The crucibles were charged with these just before welding. In the case of the sodium, efforts to clean up the material were limited to slicing away the contaminated surface with a spatula thereafter reducing the period of exposure in air to a minimum.

Following charging with either bismuth or sodium, the crucible cap was inserted, and the assembly placed in the vacuum arc melting unit (Figure 22). The water-cooled copper crucible shown in Figure 22 was replaced by a solid copper cylinder which was

[illegible]

honey-combed to contain (with snug mechanical fit) seven of the crucibles at one end, and flowing coolant (water) at the other. This fixture successfully kept the temperature of the crucibles to a minimum in those regions surrounding the contained bismuth or sodium, although welding of the capsules containing sodium proved troublesome due to vaporization of the sodium when the arc was maintained for more than a few seconds at a time. Previous to welding, the arc furnace was evacuated to an absolute pressure of less than one micron, then filled to a pressure of 1.1 atmosphere with argon bled into the arc melting cylinder through a purifying train. A tungsten electrode was utilized in the welding process.

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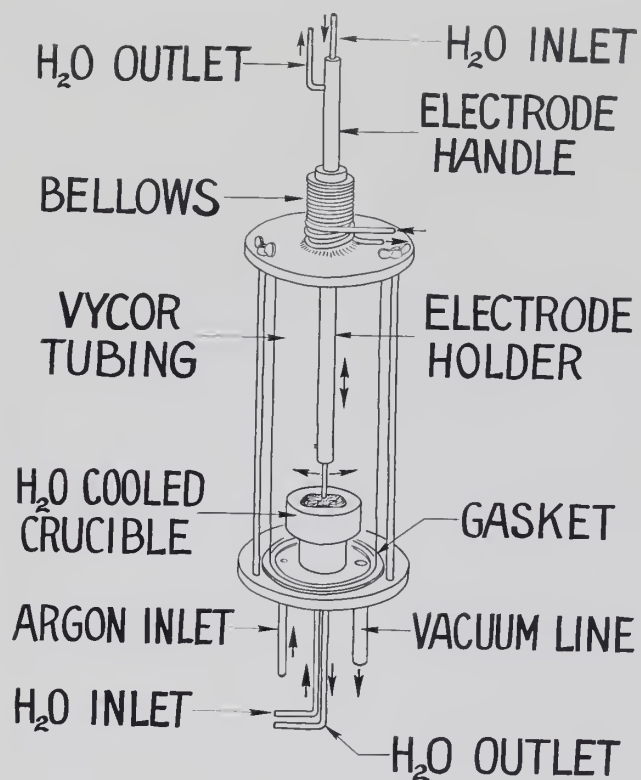


Figure 22

Drawing of arc furnace used for welding of specimens.

The following information was obtained from the records of the
United States Department of the Interior, Bureau of Land Management,
Washington, D. C., in response to a request for information made
on March 10, 1964, by the United States District Court for the
District of Columbia.

RF 2100

Page 55

Training of air turbine used for welding of specimens.

APPENDIX C

Chemical Analyses

1. Determination of vanadium in bismuth

a. Preparation for chemical analysis

Upon removal from the furnace the crucibles were placed vertically, prepared surface up, without cooling, so that particles eroded from the crucible would have a chance to settle. The crucibles, in the same position, were then quenched in cold water. The crucible material and approximately 1/32 inch of the outer surface of the bismuth slug were turned off in a lathe and the slug cut off 1/8 inch from the point where it adhered to the bottom of the crucible. The slug was then immersed in nitric acid and reduced to approximately 1/8 inch in diameter by 1/2 inch length. It was intended by this means to eliminate all vanadium from the bismuth except that which had been taken into solution during the test period. As a cross-check of the success of the process in removing all but dissolved material the remaining slugs were divided into two parts which were checked separately. If the two parts did not match within about 30% the two solutions made up from the two sections of the slug were rechecked. This accounts for the extra entries for some of the specimens in Table II.

b. Chemical procedure

(1) One fourth gram (.25 g) of each of the parts of the bismuth slug were taken into solution with 30 drops of concentrated nitric acid

(2) washed down

ARTICLE 2

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- (3) ten milliliters (10 ml) concentrated sulfuric acid added
- (4) washed down and fumed to sulfuric
- (5) step (4) repeated twice
- (6) cooled, diluted to 50 cc with distilled water
- (7) one gram of ammonium chloride added
- (8) solution transferred to 100 ml volumetric flask
- (9) 5 drops of hydrogen peroxide added
- (10) diluted to 100 ml, mixed, and color allowed 30 minutes to develop
- (11) color compared with standard sample in Beckman spectrophotometer at a wavelength of 450 millimicrons.

2. Determination of Vanadium in Sodium

a. Preparation for chemical analysis

Upon removal from the furnace, crucibles of vanadium containing sodium were quenched in cold water. The tops of the crucibles were cut off using a dry hack saw and all fillings and cuttings blown away with compressed air. The entire crucible was then immersed in distilled water for removal of the sodium. When the reaction had subsided, the interior of the crucible was flushed of remaining particles with distilled water which was added to the immersion water. The crucible contents were then in the form of solid vanadium particles and sodium bromide in water.

b. Chemical procedure

- (1) 15 ml sulfuric acid and 5 ml nitric acid added
- (2) fumed to sulfuric acid

- (3) while fuming, nitric acid added dropwise
- (4) fuming and addition of nitric acid continued until all vanadium is in solution
- (5) cooled and transferred to 100 ml volumetric flask
- (6) diluted to mark and mixed
- (7) aliquots were taken to contain not more than 200 micrograms of vanadium
- (8) five drops of hydrogen peroxide added
- (9) diluted to mark with 10% sulfuric acid, color allowed 20 minutes to develop
- (10) color measured in Beckman spectrophotometer at wavelength of 450 millimicrons
- (11) 20 ml aliquots from the original solution taken (for sodium measurement)
- (12) 10 mg iron added and an ammonium precipitation made
- (13) to the filtrate from the ammonium precipitate, sulfuric acid was added until the solution was just acid to litmus
- (14) 3 ml hydrochloric acid and 2 ml nitric acid added
- (15) solution evaporated to dryness
- (16) cooled, salts dissolved in distilled water, transferred to tared platinum dish and again evaporated to dryness
- (17) salts were taken up in water and a drop of ammonium hydroxide added
- (18) evaporated to salts and the salts heated until fumes cease and fusion begins
- (19) cooled and weighed
- (20) sodium content calculated from sodium sulfate present, and parts of vanadium per million parts of sodium determined

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3. Determination of Iron in Bismuth

a. Preparation for chemical analysis

Upon removal from the furnace, steel crucibles were held vertically for settling of particles, quenched, machined, and cleaned in a manner identical to that described in part 1 of Appendix C.

b. Chemical procedure

- (1) a weighed sample of the bismuth was placed in a 250 ml beaker and enough nitric acid added to take samples into solution
- (2) evaporated nearly to dryness
- (3) 5 ml hydrochloric acid added and taken to dryness
- (4) step (3) repeated
- (5) 10 ml hydrochloric acid added
- (6) ammonium chloride added in ratio 1 g for every 0.1 g of sample
- (7) diluted with distilled water to 100 ml
- (8) heated gently until all ammonium chloride was taken into solution
- (9) transferred to volumetric flask, diluted to mark, and aliquots taken equivalent to about 0.1 g samples
- (10) all not diluted to approximately 40 ml
- (11) added 3 ml hydroquinone solution (1%)
- (12) added 6 ml of 1-10 ortho-phenanthroline (0.25 %)
- (13) 6 ml ammonium citrate (molar solution) added, stirring between additions

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- (14) A crystalline precipitate formed
- (15) Added one-to-one ammonium hydroxide
- (16) Adjusted pH to 3.5
- (17) Solutions were transferred to 100 ml volumetric flasks,
diluted to mark, and mixed
- (18) Allowed to stand 20 hours for full color development
- (19) Optical density read in Beckman spectrophotometer
at wavelength of 513 millimicrons.

Reagent blank treated in same manner was used for correction.

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APPENDIX D

Construction, Loading and Welding of Mass Transfer Tubes

Starting with an Electrocast cast ingot of vanadium, an attempt was made to extrude vanadium tubing over a 3/4 inch mandrel. The mandrel failed in the extrusion, being "sucked out" with the metal. The remaining tube broke apart in the first pass through a swaging machine. Hardness of this material was measured as approximately R_n 46. It was postulated that the hardness might have been caused by hydrogen absorption evolved in the process of "pickling" the iron from the extruded tube. After vacuum annealing for three days at 900° C the hardness was approximately R_n 46. The idea of extruding tubing with available equipment in the in the time remaining was abandoned.

Vanadium rods were extruded as before. (see Appendix C) The iron jacket was turned off in a lathe, and the rods cut into eight inch lengths. Holes were bored through the center of the rods and reamed smooth.

Next, with metallographically polished inner surfaces were welded into the ends in an argon atmosphere using the apparatus described in Appendix A and shown in Figure 22. For welding the long tubes, the only modification to the welding apparatus was the substitution of a high class cylinder in place of the one normally used. The tubes were charged with ten grams of bismuth purified, as before, by pipetting from below the surface of a pool of molten bismuth and freezing the pipetted material.

and placed the following conditions:

- (1) The first condition was that the person should be a native-born American citizen.
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All precautions taken to prevent contamination of the crucibles described in Appendix B, such as pickling of tubes just prior to charging with bismuth, purification argon in the arc-melting unit, etc., were duplicated in preparation of the mass transfer tubes.

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APPENDIX E

Electronic Interval Timer

Calculations based on best estimates of heat conduction coefficients and constants of emissivity indicated that steady state temperatures would just be approached in the low temperature end of a tilt-tube five minutes after the bismuth came from the hot end at 900° C. The calculations were based on a full ten grams of contained metal and did not take into account depletion of the bismuth, nor was this depletion anticipated to the extent to which it occurred.

In order that the furnace remain in a tilted position for a five minute period, it was necessary to cut off power to the motor when the furnace tester-board reached an end position. This was accomplished by attaching a cam to the furnace tester-board which operated a single-pole double-throw switch instantaneously on and off again while the tester-board was going through horizontal dead center. An electronic interval timer was operated by this switch. While the microswitch was operated, it charged a 15 microfarad oil-filled paper capacitor to 220 volts from a 40 microfarad electrolytic condenser. This was done so that a large charge could be put into the 15 microfarad capacitor in the very short time that the switch was on. The electrolytic then had five minutes to recharge. A 6V6 tube, triode connected, was cut off by the voltage on the 15 microfarad capacitor for the time it took to

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discharge through one of several selected resistors. During the time it took to discharge, the tube was cut off, a relay in its plate circuit disconnected power from the motor. Positive relay action was ensured by a feedback circuit which connected the grid to a positive voltage through a two megohm resistor as soon as the relay began to close. Relay chatter was experienced until the feedback loop was added.

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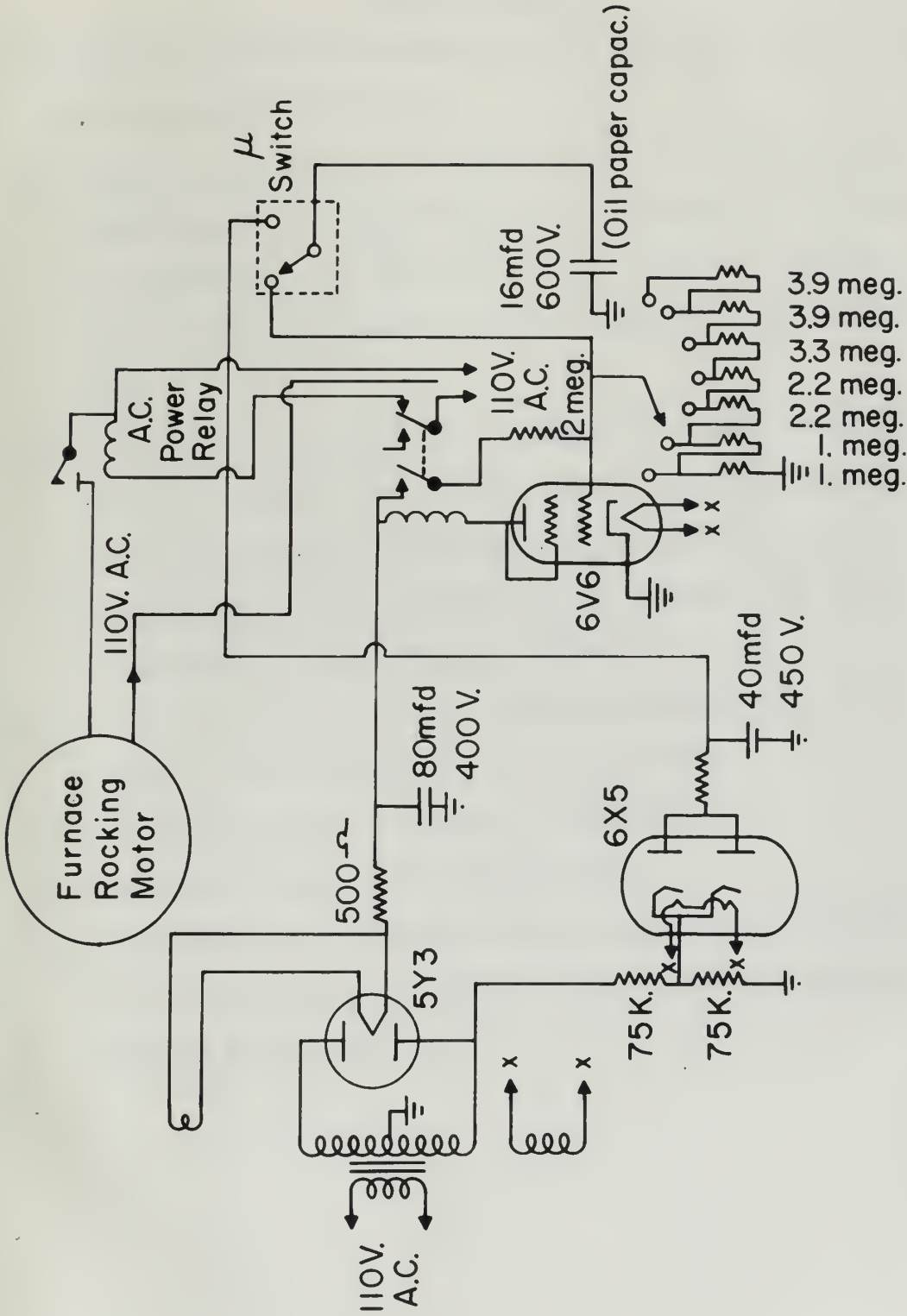


Figure 23 Electronic Interval
Timer for Mass-Transfer Experiment.

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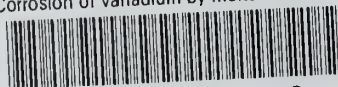
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